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United States  
Department of  
Agriculture

Food Safety  
and Inspection  
Service

# Inspection System Guide (ISG)

# INSPECTION SYSTEM GUIDE

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CATALOGING PREP

# INSPECTION SYSTEM GUIDE

## 01 FACILITIES, EQUIPMENT, WATER SUPPLY, AND SEWAGE DISPOSAL

### 01A Facilities

<b>01A01a2</b>	Floors, doors (including curtain doors), posts, partitions, and walls are impervious and in good repair. Ceiling and other overhead structures are moisture-resistant, in good repair, and leakproof.	<b>308.3(e)</b> <b>308.8(b)</b> <b>381.48</b> <b>Handbook</b> <b>570</b> <b>FSIS Dir.</b> <b>11,100.2</b>	Verify that: <ul style="list-style-type: none"><li>● Floors, doors (including curtain doors), posts, partitions, and walls are impervious and in good repair;</li><li>● Ceilings and other overhead structures are moisture-resistant, in good repair, and leakproof.</li></ul> If results do not meet compliance standards, initiate appropriate action.
<b>01A02a2</b>	Rails are located away from stationary objects and are of sufficient height to prevent product from contacting floor or other structures.	<b>Handbook</b> <b>570</b>	Verify that rails are located away from stationary objects and are of sufficient height to prevent product from contacting floor or other structures.  If results do not meet compliance standards, initiate appropriate action.
<b>01A03a2</b>	Handwashing facilities, including soap and towels, are available in all processing rooms.	<b>307.2(f)</b> <b>308.4(b)</b> <b>Sanitation</b> <b>Handbook</b>	Verify that handwashing facilities, including soap and towels, are available in all processing rooms.  If results do not meet compliance standards, initiate appropriate action.
<b>01A04a2</b>	Facilities are adequate for production volume, avoiding overly congested conditions.	<b>308.7</b> <b>Handbook</b> <b>570</b>	Verify that facilities are adequate for production volume, avoiding overly congested conditions.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 01 FACILITIES, EQUIPMENT, WATER SUPPLY, AND SEWAGE DISPOSAL

### 01A Facilities

<b>01A05a2</b>	Facilities for product reconditioning are available where needed and properly identified.	<b>7.20 Handbook 570</b>	Verify that facilities for product reconditioning are available where needed and are properly identified.  If results do not meet compliance standards, initiate appropriate action.
<b>01A06a2</b>	Adequate number of functional toilets (including tissue) and/or urinals are available in welfare facilities. Acceptable lavatories, including hot and cold water, hand towels, and soap are available.	<b>308.4(a)(b) 381.47(h) 381.51 Handbook 570</b>	Verify that an adequate number of functional toilets (including tissue) and/or urinals are available in welfare facilities. Check that acceptable lavatories, including hot and cold water, hand towels, and soap are available.  If results do not meet compliance standards, initiate appropriate action.
<b>01A07a2</b>	Storage facilities are in good repair and are adequate for the type and quantity of material being handled.	<b>FSIS Dir. 11,000.2</b>	Verify that storage facilities are in good repair and are adequate for the type and quantity of material being handled.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 01 FACILITIES, EQUIPMENT, WATER SUPPLY, AND SEWAGE DISPOSAL

### 01A Facilities

<b>01A08a2</b>	Well distributed and good quality lighting is present and meets the minimum intensity requirement.	7.3 307.2(b) 308.3(b) 308.4(a) 381.52 FSIS Dir. 11,000.1	Select a department or departments at random and observe all areas in view to determine if lighting is adequate, in good repair, properly protected, and meets minimum intensity requirements.
	Light intensities monitored by plant and meet official minimum standards at inspection and reinspection points.	7.3(l) 381.36 381.76 FSIS Dir. 11,000.1	If results do not meet compliance standards, initiate appropriate action.
	Glass, fixtures, bulbs, and skylights suspended over product are adequately protected to prevent product contamination if broken.	7.3(a) Handbook 570 FSIS Dir. 11,000.1	
<b>01A09a2</b>	Properly surfaced and drained outside premises.	308.13 381.49(b) FSIS Dir. 11,000.2 (VIII A)	Verify that outside premises are properly surfaced and drained.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 01 FACILITIES, EQUIPMENT, WATER SUPPLY, AND SEWAGE DISPOSAL

### 01B Equipment Maintenance

<b>01B01a2</b>	All product handling equipment has received design and material approval as required and conditions for use are being monitored and met by plant.	<b>308.5(b)</b> <b>381.53</b> <b>FSIS Dir.</b> <b>11,220.1</b> <b>MPI-2</b> <b>Equipment</b> <b>Book</b>	Check a sample of equipment to see that it meets criteria as outlined in MPI-2, Accepted Meat and Poultry Equipment, or that plant has current letter from FESD stating that equipment meets criteria for approval by FSIS.  If results do not meet compliance standards, initiate appropriate action.
<b>01B02a2</b>	Product zones of equipment handling edible product are smooth, readily cleaned, accessible, and in good repair.	<b>308.5(a)</b> <b>381.53</b> <b>FSIS Dir.</b> <b>11,000.2</b>	Select a sample of equipment and determine if acceptable maintenance program is being followed.  If results do not meet compliance standards, initiate appropriate action.
<b>01B03a2</b>	Compressed air that contacts product and/or equipment is filtered before entering compressor. Air storage tanks have a drain. There are water and oil traps between the storage tank and point of use.	<b>FSIS Dir.</b> <b>11,220.1</b> <b>MPI-2</b> <b>Equipment</b> <b>Book</b>	Check that compressed air contacting products and/or product contact surfaces on equipment is filtered before being used, that air storage tanks have a drain, and that there are water and oil traps between storage tanks and the point of use.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 01 FACILITIES, EQUIPMENT, WATER SUPPLY, AND SEWAGE DISPOSAL

### 01C Water and Ice Supply

<b>01C01a1</b>	Current water potability certificate supplied by State or local health agency is available. Water is clear and free from visible contamination; smell and taste are acceptable. Private wells must be on premises and shown on blueprint.	<b>8.27(a)(b)</b> <b>381.50(a)</b> <b>Handbook</b> <b>570</b>	Check that water potability certificate is current and accurate.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>01C01a2</b>			Check that water is clear and free from visible contamination and that smell and taste are acceptable. If applicable, check that private wells are on premises and shown on blueprint.  If results do not meet compliance standards, initiate appropriate action.
<b>01C02a2</b>	Automatic chlorinators are equipped with malfunction warning device. Chlorine testing kits are available and required levels are monitored and maintained by the plant. Plant keeps records of chlorine testing.	<b>8.22(a)(b)</b> <b>Handbook</b> <b>570</b> <b>Approved</b> <b>Water</b> <b>Systems</b> <b>Guide</b> <b>(Rev. 1/83)</b>	Observe chlorinators and determine if functional. Check if chlorine testing kit is available and, when possible, observe plant's chlorine-testing procedures. Evaluate plant's records of chlorine testing.  If results do not meet compliance standards, initiate appropriate action.
<b>01C03a1</b>	No cross-connections between potable and nonpotable water. Nonpotable water supply is identified and use is limited to approved applications. Letter is on file.	<b>308.3(d)</b> <b>(1)(2)(3)</b> <b>381.50(e)</b> <b>FSIS Dir.</b> <b>11,210.1</b> <b>Handbook</b> <b>570</b> <b>Sanitation</b> <b>Handbook</b>	Evaluate plant's records to determine if letter approving the use of nonpotable water is on file.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>01C03a2</b>			If nonpotable water is used, check for cross-connections and use of nonpotable water in approved areas.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 01 FACILITIES, EQUIPMENT, WATER SUPPLY, AND SEWAGE DISPOSAL

### 01C Water and Ice Supply

<b>01C04a2</b>	<p>Adequate water pressure and quantities sufficient for all operating needs are available.</p> <p>Both hot and cold water are available at well-located outlets.</p> <p>No dead-end pipelines.</p> <p>180° F water (or approved chemical in lieu of 180° F water) is available for disinfection where required.</p>	<p>308.3(d)(1)(4) 381.50(a)</p> <p>308.3(d)(5) 381.50(b)(c)</p> <p>8.23</p> <p>308.3(d)(4) MPI Bulletin 77-34 FSIS Dir. 11,000.2</p>	<p>Observe plant's water supply system for any one or all of the following:</p> <ul style="list-style-type: none"> <li>• Water pressure</li> <li>• Hot water supply</li> <li>• Dead-end pipelines</li> </ul> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>01C05a2</b>	<p>Submerged water lines have functional backflow preventers. Backflow preventers are on steam lines where needed.</p>	<p>8.26 308.3(d)(1) 381.50(a) Handbook 570</p>	<p>Select one or more back-siphonage devices on submerged water lines and steam lines and check to determine if functional.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>01C06a1</b>	<p>Backflow devices are tested at least yearly and the results are documented. FSIS is notified in writing of location of each back-flow device and actions taken when a device fails a test; updated when needed.</p>	<p>Approved Water Systems Guide (Rev. 1/83)</p>	<p>Review for documentation of backflow device tests.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>01C06a2</b>			<p>Check to determine if the location of backflow devices is accurate as identified on the record.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 01 FACILITIES, EQUIPMENT, WATER SUPPLY, AND SEWAGE DISPOSAL

### 01C Water and Ice Supply

<b>01C07a1</b>	Current ice potability certificate from outside supplier or where otherwise required is on file. Ice from outside source is clean, properly packaged, and handled in a sanitary manner.	<b>8.27</b> <b>8.24</b> <b>381.66(c)</b> <b>Sanitation Handbook</b>	Check that current ice potability certificate is on file.  If results do not meet compliance standards, initiate appropriate action.
<b>01C07a2</b>			Observe ice received from outside sources to determine if FSIS requirements have been met.  If results do not meet compliance standards, initiate appropriate action.
<b>01C07b2</b>	Ice-making equipment and storage bins are of stainless steel or rust-resistant materials and equipped with perforated metal drainage plates.	<b>8.24</b> <b>8.27</b> <b>381.66(c)</b> <b>Sanitation Handbook</b>	Observe ice making equipment, ice storage facilities for acceptability.  If results do not meet compliance standards, initiate appropriate action.
<b>01C08a2</b>	Approved procedures for handling re-used ice are on file. Procedures are implemented and monitored as approved.	<b>8.24</b> <b>Approved Water Systems Guide (Rev. 1/83)</b>	Check that approved ice re-use procedures are on file and observe if the procedures are followed.  If results do not meet compliance standards, initiate appropriate action.
<b>01C09a2</b>	Approved program for water re-use is on file. Program is implemented and monitored by the plant as approved.	<b>8.25(a)(b)</b> <b>308.3(d)(2)(3)</b> <b>381.50(e)(f)</b> <b>Sanitation Handbook Approved Water Systems Guide (Rev. 1/83)</b>	Check that approved water re-use program is on file and observe if the procedures are followed.  If results do not meet compliance standards, initiate appropriate action.



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## 01 FACILITIES, EQUIPMENT, WATER SUPPLY, AND SEWAGE DISPOSAL

### 01D Sewage

<b>01D01a2</b>	Sewage system is approved and approval letter is on file. Floor drains are properly trapped. Plant notifies FSIS when/if modifications to sewage system occur. Toilet lines do not discharge into grease catch basin.	<b>304.2(e)(1)</b> <b>308.3(c)</b> <b>308.13</b> <b>Sanitation Handbook</b>	Using blueprint, observe an area of the sewage and drainage system (where applicable). Observe grease basins and drainage ponds to determine if unacceptable conditions exist. Make sure that plant has notified FSIS when/if modifications to sewage system occur.  If results do not meet compliance standards, initiate appropriate action.
<b>01D02a2</b>	Waste disposal facilities are adequate for the quantity and type of material being handled.	<b>Handbook</b> <b>570</b> <b>FSIS Dir.</b> <b>11,000.2</b>	Verify that waste facilities are adequate for the quantity and type of material being handled.  If results do not meet compliance standards, initiate appropriate action.
<b>01D03a2</b>	Method and frequency of waste removal is sufficient to prevent accumulation of waste or other undesirable conditions.	<b>8.34(d)</b> <b>308.13</b> <b>381.47(b)</b> <b>FSIS Dir.</b> <b>11,000.2</b>	Check that plant refuse is removed at least daily. Burning of plant refuse must be by local authority and only with approved facilities.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 01 FACILITIES, EQUIPMENT, WATER SUPPLY, AND SEWAGE DISPOSAL

### 01E Blueprints

<b>01E01a2</b>	Currently approved blueprints and specifications are on file.	<b>304.2 381.19 Handbook 570 FSIS Dir. 11,100.1</b>	Observe various plant areas, departments, major equipment, etc., and compare to currently approved blueprints and specifications.  If results do not meet compliance standards, initiate appropriate action.
<b>01E02a2</b>	Facilities and equipment installation complies with blueprints.	<b>7.10 304.2 381.19 Handbook 570</b>	Check various plant areas to assure that the installation of facilities and equipment complies with blueprints.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 02 SANITATION OF FACILITIES AND EQUIPMENT/PERSONAL HYGIENE

### 02A Preoperational Sanitation of Facilities, Equipment/Personal Hygiene

<b>02A01a1</b>	Trained competent plant employees are identified as responsible for the sanitation program and preoperative inspection. The designated employees allow operations to begin only after all sanitation requirements are met. Facilities, and all product handling equipment, including hand-	<b>11.1(d)</b> <b>308.8</b> <b>381.57</b> <b>381.58</b> <b>FSIS Dir.</b> <b>11,040.1</b> <b>Sanitation</b> <b>Handbook</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>02A01a2</b>	contact equipment, is cleaned daily. QC program is implemented and monitored by the plant as approved, including corrective action when needed.		Check one or more areas or departments to determine if plant/equipment conditions are acceptably clean. (Examples: floors; walls; ceilings; overhead structures; windows; screens; freezers; coolers; dry storage areas; rails; equipment.) Specific attention should be given to product contact surfaces.  If results do not meet compliance standards, initiate appropriate action.
<b>02A02a1</b>	All major equipment is disassembled for cleaning and inspection. CIP systems are as effective as those for cleaning disassembled equipment. QC program is implemented and monitored by the plant as approved, including corrective action when needed.	<b>8.2</b> <b>8.30</b> <b>308.3</b> <b>308.7</b> <b>FSIS Dir.</b> <b>11,000.2</b> <b>11,040.1</b> <b>Sanitation</b> <b>Handbook</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>02A02a2</b>			Check that major equipment is disassembled for cleaning and inspection and that CIP systems are just as effective as those for cleaning disassembled equipment.  If results do not meet compliance standards, initiate appropriate action.



# **INSPECTION SYSTEM GUIDE**

## **02 SANITATION OF FACILITIES AND EQUIPMENT/PERSONAL HYGIENE**

### **02A Preoperational Sanitation of Facilities, Equipment/Personal Hygiene**

**02A03a1**

Preoperational swab sample is taken prior to start of operations. Approved microbiological monitoring program is implemented and monitored by the plant as approved, including corrective actions where required.

**FSIS Dir.  
11,000.2  
(XI 7,8)  
Approved  
QC Program**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

**02A03a2**

Observe swabbing techniques to assure the proper type of swabs and diluent are used. Assure the proper sampling area is swabbed.

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 02 SANITATION OF FACILITIES AND EQUIPMENT/PERSONAL HYGIENE

### 02B Operational Sanitation of Facilities, Equipment/Personal Hygiene

**02B01a1**

Facilities (freezers, coolers, refrigeration units, dry storage areas, etc.) are maintained in a sanitary and orderly manner and floors are free of accumulations. Walls and doors are maintained in a sanitary manner. Ceilings and overhead structures are free of dust, flaking paint, plaster, rust, condensation, etc. QC program is implemented and monitored by the plant as approved, including corrective action when needed.

**02B01a2**

308.3(e)(g)  
308.8(b)  
381.48(a)(b)(c)  
381.57  
Sanitation  
Handbook  
FSIS Dir.  
11,000.2  
Approved  
QC Program

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

Select one or more departments/ areas and check to see that:

- Debris/slime accumulations on floor are prevented or removed
- Window ledges are free from dirt, dust, and equipment
- Overhead structures are free from rust, etc.
- Coolers, freezers, and dry storage areas are orderly
- Product is stored in an acceptable manner
- Floors are scraped or swept
- Floor drains are properly draining and functional.

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 02 SANITATION OF FACILITIES AND EQUIPMENT/PERSONAL HYGIENE

### 02B Operational Sanitation of Facilities, Equipment/Personal Hygiene

<b>02B02a1</b>	Appropriate and effective measures are taken to prevent contamination of product (raw, cooked, or in process) or equipment from condensate or other contaminants. QC program is implemented and monitored by the plant as approved, including corrective action when needed.	<b>FSIS Dir. 11,000.2 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>02B02a2</b>			If results do not meet compliance standards, initiate appropriate action.  _____  Tour establishment and observe plant areas to verify if condensation or other contamination is controlled or area is rejected/product retained. Retain contaminated product and require reconditioning or condemnation. Identify chronic problem areas/situations and set up effective long-range permanent corrective action.
<b>02B03a1</b>	Product-handling equipment, including hand-contact equipment and operating devices, is cleaned free of all residue and foreign material. QC program is implemented and monitored by the plant as approved, including corrective action when needed.	<b>308.5(a) 381.58 Handbook 570 FSIS Dir. 11,000.2 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>02B03a2</b>			If results do not meet compliance standards, initiate appropriate action.  _____  Select one or more areas or departments and check equipment product contact zones and hand-contact operating devices to determine if conditions are acceptable.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 02 SANITATION OF FACILITIES AND EQUIPMENT/PERSONAL HYGIENE

### 02B Operational Sanitation of Facilities, Equipment/Personal Hygiene

<p><b>02B04a1</b></p>	<p>Any work surface, machine, or tool that contacts raw product shall be thoroughly cleaned and sanitized with a solution germicidally equivalent to 50 ppm chlorine before it contacts cooked product. QC program is implemented and monitored by the plant as approved, including corrective action when needed.</p>	<p><b>318.17(j)(1) FSIS Dir. 11,000.2 Approved QC Program</b></p>	<p>Evaluate available records to determine if on file, timely, accurate, and complete.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p> <hr/> <p>Check and observe cleaning and sanitizing of one or more pieces of equipment and/or one or more areas for compliance. Verify sanitizer strength by daily report or one or more tests from plant employees.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<p><b>02B04a2</b></p>			<hr/> <p>Evaluate available records to determine if on file, timely, accurate, and complete.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p> <hr/> <p>Check the room temperature in raw product areas to determine if 50° F or less is maintained. If temperature is exceeded, require midshift cleanup of all equipment surfaces contacting product. <b>Exception:</b> Complex equipment that will be used within 3 hours: product coming in contact with this equipment will be processed within 4 hours of its temperature rising to 50 degrees F.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<p><b>02B05a1</b></p>	<p>Midshift cleanup of raw product processing room when temperature exceeds 50° F. Midshift cleanup is accomplished within 5 hours of startup and every 5 hours thereafter. All product contact surfaces are cleaned. QC program is implemented and monitored by the plant as approved, including corrective action when needed.</p>	<p><b>FSIS Dir. 11,000.2 Sanitation Handbook Approved QC Program</b></p>	<hr/> <p>Evaluate available records to determine if on file, timely, accurate, and complete.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p> <hr/> <p>Check the room temperature in raw product areas to determine if 50° F or less is maintained. If temperature is exceeded, require midshift cleanup of all equipment surfaces contacting product. <b>Exception:</b> Complex equipment that will be used within 3 hours: product coming in contact with this equipment will be processed within 4 hours of its temperature rising to 50 degrees F.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<p><b>02B05a2</b></p>			

# INSPECTION SYSTEM GUIDE

## 02 SANITATION OF FACILITIES AND EQUIPMENT/PERSONAL HYGIENE

### 02B Operational Sanitation of Facilities, Equipment/Personal Hygiene

<b>02B06a1</b>	Equipment surfaces directly contacting heat-processed product are to be washed and sanitized at midshift. Equipment is not to be used interchangeably from raw to heat-processed product. Portable equipment to be washed and sanitized in designated areas. QC program is implemented and monitored by the plant as approved, including corrective action when needed.	<b>FSIS Dir. 11,000.2 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>02B06a2</b>			Observe midshift cleanup procedures to determine if all product contact surfaces are washed and sanitized.  If results do not meet compliance standards, initiate appropriate action.
<b>02B06b1</b>	Equipment swab (micro) samples taken within required time after starting operations and additional samples taken during approximately stated time intervals. QC program is implemented and monitored by the plant as approved, including corrective action when needed.	<b>FSIS Dir. 11,000.2 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>02B06b2</b>			Observe swabbing techniques to assure that the proper type of swabs and diluent are used. Assure the proper sampling area is swabbed at proper time intervals.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 02 SANITATION OF FACILITIES AND EQUIPMENT/PERSONAL HYGIENE

### 02B Operational Sanitation of Facilities, Equipment/Personal Hygiene

<b>02B07a1</b>	Adequate and clean welfare facilities are provided. QC program is implemented and monitored by the plant as approved, including corrective action when needed.	<b>308.4(a) FSIS Dir. 11,000.2 Sanitation Handbook Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>02B07a2</b>			Check locker rooms, rest rooms, lunch rooms. Check handwashing facilities to determine if areas are properly cleaned, monitored, and maintained and that supplies such as towels, soap, etc., are adequately maintained.  If results do not meet compliance standards, initiate appropriate action.
<b>02B08a1</b>	Lockers are to be kept clean and in good repair. QC program is implemented and monitored by the plant as approved, including corrective action when needed.	<b>FSIS Dir. 11,000.2 Sanitation Handbook Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>02B08a2</b>			Inspect open lockers to determine if they are kept clean and in good repair.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 02 SANITATION OF FACILITIES AND EQUIPMENT/PERSONAL HYGIENE

### 02B Operational Sanitation of Facilities, Equipment/Personal Hygiene

<b>02B09a1</b>	Outside premises are clean and orderly. No accumulation of debris, old equipment, weeds, or junk. QC program is implemented and monitored by the plant as approved, including corrective action when needed.	<b>308.13 FSIS Dir. 11,000.2 Sanitation Handbook Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>02B09a2</b>			Tour outside premises to determine if accumulations of scrap materials, equipment, barrels, etc., are properly handled, stored, or removed.  If results do not meet compliance standards, initiate appropriate action.
<b>02B10a1</b>	Dry ice dispensers are mechanically vented. Exhaust intakes are located near the floor. Rooms or areas where dry ice is used or stored must be properly identified [sign(s) posted]. CO <sub>2</sub> does not exceed 0.5% level in areas where it is used. A measuring device is available where dry ice is used. CO <sub>2</sub> levels are routinely monitored by a designated plant employee. Corrective measures are taken when limits are exceeded. QC program is implemented and monitored by the plant as approved, including corrective action when needed.	<b>FSIS Dir. 11,000.2 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>02B10a2</b>			Check to see if CO <sub>2</sub> warning signs are posted in areas where dry ice-packed products are stored. When dry ice dispenser is in use, check to see if the vent fan and floor inlet are functioning, with CO <sub>2</sub> being exhausted to the outside of the building. Assure that CO <sub>2</sub> cloud or fog does not form around the dispenser, and if present require plant to measure concentration of CO <sub>2</sub> to assure 0.5% level is not exceeded.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 02 SANITATION OF FACILITIES AND EQUIPMENT/PERSONAL HYGIENE

### 02C Personal Hygiene Practices

<b>02C01a2</b>	Employee outer garments are clean, in good repair, and of readily washable materials. Clothing that becomes soiled or contaminated during the workday is changed as often as necessary. Employees working where exposed product is handled wear suitable head coverings to prevent hair from falling into product.	<b>308.8(d)</b> <b>381.61(b)(c)</b> <b>FSIS Dir.</b> <b>11,000.2</b> <b>11,520.2</b> <b>Sanitation Handbook</b>	Observe at random employees' hygienic habits, outer garments, gloves, aprons, jewelry, etc., to determine if the potential for product contamination or adulteration exists.  If results do not meet compliance standards, initiate appropriate action.
<b>02C02a2</b>	Employees in heat-processed areas remove outer garments before leaving area and hang in designated area. Outer garments identified for use with cooked product only.	<b>318.17(j)(3)</b> <b>FSIS Dir.</b> <b>11,520.2</b> <b>(Rev. 1)</b>	Check to determine that outer garments worn by employees working in heat-processed product areas are hung in a designated area or replaced each time the employees enter the heat-processed product areas.  If results do not meet compliance standards, initiate appropriate action.
<b>02C03a2</b>	Procedures are in place to assure that only sanitary practices are used (e.g., no tobacco is used, rest room requirements are met, hands are clean, aprons and tools are properly stored during breaks.) Exposed product is not handled by persons exhibiting disease, open sores, or improper dressings on cuts.	<b>8.17</b> <b>308.8(e)</b> <b>308.14</b> <b>381.61(c)(d)</b> <b>FSIS Dir.</b> <b>11,000.2</b>	Observe at random employees' sanitary practices to assure that sanitary procedures are followed and that exposed product is not handled by persons exhibiting disease, open sores, or improper dressings on cuts.  If results do not meet compliance standards, initiate appropriate action.
<b>02C04a2</b>	Steps are taken to assure that employees do wash their hands and sanitize them with a solution germicidally equivalent to 50 ppm chlorine whenever they enter the heat-processed product area or before preparing to handle cooked product, and as frequently as necessary during operations to avoid product contamination.	<b>8.55</b> <b>318.17(j)(2)</b> <b>FSIS Dir.</b> <b>11,520.2</b> <b>(Rev. 1)</b>	Observe at random employees washing and sanitizing hands with a germicidal solution equivalent to 50 ppm chlorine before entering a heat-processed product area or before handling cooked product and as necessary to avoid product contamination.  If results do not meet compliance standards, initiate appropriate action.



# **INSPECTION SYSTEM GUIDE**

## **03 SLAUGHTER**

**Reserved**

**May 1, 1988**

**3-1**





# INSPECTION SYSTEM GUIDE

## 04 PEST AND RODENT CONTROL

### 04A Pest and Rodent Control Program

<b>04A01a1</b>	Integrated pest control program is on file.	<b>8.47(d) 8.51 FSIS Dir. 11,000.2 Sanitation Handbook</b>	Evaluate available records to determine if pest control program is on file and effectively maintained.
	Precautions are taken to exclude vermin.		If results do not meet compliance standards, initiate appropriate action.
<b>04A01a2</b>	No rodent harborages inside or outside plant.	<b>8.46(c) 308.3(h) 381.59 Handbook 570</b>	Observe plant's premises and determine if pest and rodent control program is effective.
			If results do not meet compliance standards, initiate appropriate action.
<b>04A02a1</b>	Pest control devices are properly installed and monitored and a map showing the location of bait boxes, traps, and other devices is on file.	<b>8.49 Handbook 570</b>	Evaluate available records to determine if required map is on file, timely, accurate, and complete.
			If results do not meet compliance standards, initiate appropriate action.
<b>04A02a2</b>			Check all or a sample of pest control stations against the current map to determine if pest control devices are accounted for and properly maintained.
			If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 04 RODENT AND PEST CONTROL

### 04A Rodent and Pest Control Program

**04A03a2**

No evidence of rodent activity in production or production-related areas.

**8.46**  
**8.50(b)**  
**381.59**  
**Sanitation**  
**Handbook**

Check the production area or a sample of the area for rodent activity. If evidence of rodent activity is detected:

- Suspend operations and the movement of products into or out of product area
- Destroy or decharacterize all affected products
- Require survey of plant premises
- Remove accumulations of harborage material

Allow production to resume when all actions are acceptably completed.

**04A04a2**

No evidence of insects in production or production-related areas.

**8.46**  
**Sanitation**  
**Handbook**

Check the production area or a sample of the area to determine if the insect control program is effective.

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 04 RODENT AND PEST CONTROL

### 04B Pesticides and Rodenticides

<b>04B01a1</b>	Pesticides being used are properly identified and EPA-registered. Use is as label requires. Current list of pesticides used in the plant is maintained.	8.46-8.51 308.3(h) 381.60(a)(b) FSIS Dir. 11,000.2 Sanitation Handbook List of Proprietary Substances and Nonfood Compounds	Evaluate available pesticide list to determine if on file, timely, accurate, and complete.
<b>04B01a2</b>			If results do not meet compliance standards, initiate appropriate action.  Review a sample of pesticide labels, if applicable, and determine if properly identified, EPA-registered, and used as label requires.  If results do not meet compliance standards, initiate appropriate action.
<b>04B02a2</b>	Storage and area of approved chemicals are acceptable to FSIS. Approved chemicals kept in closed containers and under the control of an identified plant employee.	8.47(c) 8.49(b)	Check to determine if storage and area of approved chemicals is acceptable and that they are in closed containers and under the control of an identified plant employee.  If results do not meet compliance standards, initiate appropriate action.
<b>04B03a2</b>	Application of EPA-restricted pesticides is by licensed and certified vendors. EPA general-use pesticides may be applied only by responsible plant employee.	8.47(a)(b) 8.48(a) Sanitation Handbook	Observe evidence of application (vendor or plant employee) to determine if EPA regulations and FSIS requirements are met.  If results do not meet compliance standards, initiate appropriate action.





# INSPECTION SYSTEM GUIDE

## 05 RECEIVING AND CONTROL OF INCOMING PRODUCTS/MATERIALS

### 05A Receiving

<b>05A01a1</b>	<p>Meat and/or poultry product received bears legible marks of inspection or is packed in properly labeled containers. Incoming product is examined for cleanliness and wholesomeness. FSIS is notified of unacceptable condition. Poultry is 40° F or less. Receiving records are kept current and accurate and reinspection is done as required. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.</p>	<p>18.2 18.12 18.19(a)(2) 318.1 318.2 318.6 381.66(b) 381.145(a)(b) Approved QC Program</p>	<p>Evaluate available records to determine if on file, timely, accurate, and complete.</p>
<b>05A01a2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Select a sample from one or more containers; whole carcasses; half-carcasses; quarter-carcasses; or product on hooks. Inspect samples to determine if product is wholesome and properly identified. Take temperature of poultry. Compare results to receiving records.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>05A01b1</b>	<p>Plant specifies requirements for temperature, fat content, or weight range in approved QC program. QC programs are implemented and monitored by the plant as approved.</p>	<p>Approved QC Program</p>	<p>Evaluate available records to determine if on file, timely, accurate, and complete.</p>
<b>05A01b2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Observe plant employees' inspection methods for all items identified in approved QC as receiving inspection responsibility. Compare findings to plant's records and compliance standards.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 05 RECEIVING AND CONTROL OF INCOMING PRODUCTS/MATERIALS

### 05A Receiving

<b>05A01c1</b>	Product received bears legible grade or certification marks or is packed in grade-labeled or certified-labeled containers. Each shipment of product is recorded on inventory record. QC program is implemented and monitored by plant as approved, including corrective action when needed.	<b>FSIS Dir. 6810.1 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>05A01c2</b>			Observe one lot of product at receiving for grade labeling or product identification. Also, verify recording of one lot of product into the inventory record.  If results do not meet compliance standards, initiate appropriate action.
<b>05A02a1</b>	Letters of guaranty are on file for applicable nonmeat ingredients and/or dairy products not produced in a USDA plant or labeled as "Food Grade" or "Food Chemical Codex." Products are examined for wholesomeness. FSIS is notified of unacceptable conditions. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.20 318.1(c) 318.6(10) 381.147 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>05A02a2</b>			Check one or more different ingredients to determine if letters of guaranty are current and ingredients are clean and properly identified.  If results do not meet compliance standards, initiate appropriate action.



# **INSPECTION SYSTEM GUIDE**

## **05 RECEIVING AND CONTROL OF INCOMING PRODUCTS/MATERIALS**

### **05A Receiving**

**05A03a1**

Nonfood chemicals are approved and properly identified. Chemical monitoring list is current and acceptable. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**318.1(c)(e)(j)**

**318.7(c)(4)**

**318.15**

**381.60**

**381.147(f)(4)**

**FSIS Dir.**

**11,000.2**

**List of**

**Proprietary**

**Substances**

**and Nonfood**

**Compounds**

**Approved**

**QC Program**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

**05A03a2**

Check one or more incoming nonfood chemicals to determine if they are in the List of Proprietary Substances and Nonfood Compounds publication or identified by a current authorization letter signed by an authority from the Food Ingredient Assessment Division, Science.

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 05 RECEIVING AND CONTROL OF INCOMING PRODUCTS/MATERIALS

### 05B Storage

<b>05B01a1</b>	All product is stored in a manner that effectively prevents contamination and/or spoilage. Poultry product 40° F or less. Hanging carcasses are not allowed to contact fixed objects or containers. Exposed products are suitably protected from contamination. Good warehousing is practiced to prevent damage or contamination to containers. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>308.3(f)</b> <b>308.7</b> <b>308.8</b> <b>308.9</b> <b>318.5(a)(1)</b> <b>381.66</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>05B01a2</b>			If results do not meet compliance standards, initiate appropriate action. _____  Observe one or more meat/poultry storage areas to determine if conditions are acceptable.  If results do not meet compliance standards, initiate appropriate action.
<b>05B01b1</b>	Product segregation is approved and a QC program is on file. QC implemented and monitored by plant as approved, including corrective action when required.	<b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action. _____
<b>05B01b2</b>			Verify that one lot of applicable product has been segregated in the cooler or freezer as identified in the QC program.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 05 RECEIVING AND CONTROL OF INCOMING PRODUCTS/MATERIALS

### 05B Storage

<b>05B02a1</b>	Supplies of nonmeat ingredients and/or packaging material are stored and used in an acceptable manner that precludes contamination of product.	<b>308.9 FSIS Dir. 7410.1 11,000.2</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>05B02a2</b>	Nonmeat ingredients are properly identified and labeled. Restricted materials such as binders, extenders, etc., are stored in an acceptable manner, with current and accurate inventory maintained as applicable.	<b>18.20 18.21</b>	If results do not meet compliance standards, initiate appropriate action.
	Nonmeat food items are stored on racks 12 inches off floor. All other materials stored on racks or closely arranged and frequently moved to facilitate cleaning and inspection.	<b>FSIS Dir. 11,000.2 (VIII D) Sanitation Handbook</b>	Observe all or a section of dry storage to determine if conditions are acceptable. Check to verify that products are properly identified and stored; that no used equipment is stored; and that nonfood products are removed. Randomly select a sample of restricted ingredients and compare findings with inventory records.
	QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	If results do not meet compliance standards, initiate appropriate action.
<b>05B03a1</b>	Chemicals are properly stored and used for intended purpose. Soaps, detergents, or denaturing agents are not stored in product-handling areas. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>381.60 FSIS Dir. 11,000.2 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>05B03a2</b>			If results do not meet compliance standards, initiate appropriate action.
			Check chemicals to assure that they are properly used, stored, and labeled.
			If results do not meet compliance standards, initiate appropriate action.





# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06A Sausage Processing

<b>06A01a1</b>	Fresh sausage, Italian sausage, uncooked smoked sausage, cooked sausage, meat and/or nonmeat ingredients properly identified, pre-blended, and formulated according to approved Label Application Form 8822. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.21</b> <b>18.24</b> <b>318.6</b> <b>318.7(c)</b> <b>319</b> <b>Subparts</b> <b>E, F, G</b> <b>Labeling</b> <b>Policy Book</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06A01a2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Select at random one or more batches of products during formulation and check one or more ingredients for proper identification and use of accurate weights. Calculate for minimum amount of meat/meat byproduct components and maximum amount of one or more restricted ingredients used to determine compliance with approved formula.</p>
<b>06A02a1</b>	Rework product used in similar product at specified levels. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.24(a)(5)</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06A02a2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Select one or more lots/batches of product and verify the amount of rework added to like product is at the rate identified in the approved QC program.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06A Sausage Processing

06A03a1	Casings (natural or artificial) are properly identified, wholesome. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	18.24(a)(3) Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
06A03a2			Examine casings at stuffing operation.  If results do not meet compliance standards, initiate appropriate action.
06A04a1	Precooking operation meets yield standards (breakfast sausage). QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	319 Subpart E Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
06A04a2			Randomly select one or more units from production line and weigh before cooking. Select one or more units after cooking (before packaging) and weigh. To determine yield:  $\frac{\text{Cooked Wt.}}{\text{Green Wt.}} = \% \text{ Yield}$  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06A Sausage Processing

<b>06A05a1</b>	Cooking units, temperature sensing equipment, and recording devices are properly calibrated. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06A05a2</b>			If results do not meet compliance standards, initiate appropriate action.  _____
<b>06A06a1</b>	Cooked/smoked minimum internal temperatures are met. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.4 318.10(b)(c) Approved QC Program Approved Label</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06A06a2</b>			If results do not meet compliance standards, initiate appropriate action.  _____
			Select at random and check internal temperature of one or more pieces/units of product from one or more trees, cages, racks, etc., located in different areas of the heating unit.
			If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06A Sausage Processing

<b>06A07a1</b>	Cook/shrink of product is within limits. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06A07a2</b>			Perform and calculate shrink of one batch of product using the formula:  $\frac{\text{Weight in} - \text{Weight out}}{\text{Weight in}} \times 100$  If results do not meet compliance standards, initiate appropriate action.
<b>06A08a1</b>	Chilling time and/or shrink is within limits. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06A08a2</b>			Observe weighing of product and/or weigh product after chilling to determine shrink.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06B Cured Pork Processing (PFF, X% Added Ingredients)

<b>06B01a1</b>	Pickle solution formulated with accurately weighed or metered restricted ingredients as identified in approved procedure and/or QC program. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.20(e)(6) 18.32 318.7(c) Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06B01a2</b>			Observe formulation of one solution to verify accuracy. Select one or more ingredients, weigh, and compare to formula. Calculate restricted ingredient level to ensure maximum level is not exceeded.  If results do not meet compliance standards, initiate appropriate action.
<b>06B02a1</b>	Each lot identified and green weight established. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06B02a2</b>			Verify lot identification and established green weight on one lot of product.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06B Cured Pork Processing (PFF, X% Added Ingredients)

<b>06B03a1</b>	The addition of solution complies with limits established in processing procedure and/or QC program. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.32</b> <b>318.19</b> <b>319.104</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06B03a2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p style="text-align: center;">_____</p> <p>Observe method of applying solution. Observe adjustment of machines or weighing of bulk product to see if approved procedure is followed. Select one or more pieces of product or one or more batches. Weigh before and after solutions are applied. Determine percent gain using the formula:</p> $\frac{\text{Pumped Wt} - \text{Green Wt}}{\text{Green Wt}} \times 100$ <p style="text-align: center;">or</p> $\frac{\text{Massaged/Tumbled Wt} - \text{Green Wt}}{\text{Green Wt}} \times 100$ <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06B04a1</b>	Addition of cover pickle meets standards. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.32</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06B04a2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p style="text-align: center;">_____</p> <p>Verify the addition of cover pickle.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06B Cured Pork Processing (PFF, X% Added Ingredients)

06B05a1	Ground ham formulation and addition of ground ham or trimmings meets the standard. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	18.32 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
06B05a2			Verify the formulation and addition of ground ham or trimmings for one batch of product.  If results do not meet compliance standards, initiate appropriate action.
06B06a1	Drain loss and/or stuffing loss to meet standard. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
06B06a2			Observe plant's monitoring of drain losses for one or more smokehouse trees or vats for product weight ranges or observe plant's verification of stuffing loss on one or more batches or vats of product.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06B Cured Pork Processing (PFF, X% Added Ingredients)

<b>06B07a1</b>	Smokehouse or cooking vat controls (wet bulb/dry bulb) and recording devices are accurate. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06B07a2</b>			Observe calibration of wet bulb/dry bulb thermometers and recording devices at one or more smokehouses or one or more cooking vats.  If results do not meet compliance standards, initiate appropriate action.
<b>06B08a1</b>	Product cooked to minimum internal temperature or temperature as stated in approved procedures. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.32 318.10 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06B08a2</b>			Check one or more units of product in smokehouse or cooking vats for internal temperature.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06B Cured Pork Processing (PFF, X% Added Ingredients)

06B09a1	Cook shrink meets standard. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	18.32 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
06B09a2			Calculate cook shrink on one or more trees or one batch of product using the formula:  $\frac{\text{Weight in} - \text{Weight out}}{\text{Weight in}} \times 100$  If results do not meet compliance standards, initiate appropriate action.
06B10a1	Chill shrink meets standards. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	18.32 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
06B10a2			Calculate cooler shrink on one or more batches of product.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06B Cured Pork Processing (PFF, X% Added Ingredients)

**06B11a1**

Label declaration for percent of "weight is added ingredients" meets percentage label declaration. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**06B11a2**

#### 318.4 Approved QC Program

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

Verify the yield on one lot of product to assure it complies with label percentage declaration of "weight is added ingredients" using the formula:

$$\frac{\text{Finished Wt} - \text{Green Wt}}{\text{Finished Wt}} \times 100$$

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06C Minimum Meat/Poultry Product

<b>06C01a1</b>	Meat, poultry and/or nonmeat ingredients are properly identified and formulated in compliance with posted formula and product standard. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>319</b> <b>Subparts</b> <b>K, L, M, N,</b> <b>O, Q, R</b> <b>319.881</b> <b>381.157</b> <b>381.158</b> <b>381.167</b> <b>Approved</b> <b>QC Program</b> <b>Labeling</b> <b>Policy Book</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06C01a2</b>			If results do not meet compliance standards, initiate appropriate action.
<b>06C02a1</b>	Cooked meat/poultry substituted for fresh meat equivalent meets standard.	<b>18.35</b> <b>18.36</b> <b>381.157</b> <b>381.158</b> <b>381.167</b> <b>381.168</b> <b>FSIS Dir.</b> <b>7124.1</b> <b>Approved</b> <b>QC Program</b> <b>Labeling</b> <b>Policy Book</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06C02a2</b>			If results do not meet compliance standards, initiate appropriate action.
			Perform calculation to determine cooked meat/poultry compliance.
			If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06C Minimum Meat/Poultry Product

06C03a1	Approved QC programs for fill weight, meat content formulation, process, and nonmeat ingredient control are implemented and monitored by the plant, including corrective action where required.	Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06C03a2			Weigh a subgroup of one or more units that has been weighed and passed. Calculate the average, range, run criteria, and individual limits. Compare results to compliance standards in QC program.  If results do not meet compliance standards, initiate appropriate action.
06C04a2	All product cooked to minimum internal temperature.	18.37 318.10 381.150 Label Approval	Select at random one type of product during cooking and check internal product temperatures from different places in heating unit.  If results do not meet compliance standards, initiate appropriate action.
06C05a1	During rapid cooling of product, the internal temperature does not remain between 130° F and 80° F for more than 1½ hours, nor between 80° F and 40° F for more than 5 hours. Product consisting of intact muscle (e.g., turkey breast or pork loin) may be cooled according to 318.17. Cold storage temperatures, intermediate holding temperatures, and hot holding temperatures are met per FSIS Directive 7110.3, approved QC program, or 318.17.	318.17 FSIS Dir. 7110.3 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06C05a2			Verify internal temperature, cold storage temperature, intermediate holding temperature, and hot holding temperature of one or more units of cooked product for compliance.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06D Boning/Cutting/Breaking

<b>06D01a2</b>	Steaks, roasts, chops, ham slices, etc., are wholesome and properly identified as to species, cut size, etc.	<b>Part 17 316 Labeling Policy Book</b>	<p>Select at random one or more containers of product (steaks, roasts, chops, ham slices, etc.) during preparation or packaging and verify the product is properly identified and wholesome.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06D02a2</b>	Poultry cut-up/boning. Product is wholesome and properly identified. Internal temperature is 40° F or less prior to cut-up; not more than 55° F internal temperature during further processing/packaging; product chilled to 40° F internal temperature or less immediately after packaging or cooked immediately.	<b>8.55(e) 381.66(b) 381.170 MP Bulletin 456</b>	<p>Select at random and check internal temperature of one or more pieces/pounds of product prior to cut-up, during processing, packaging, or immediately after chilling to determine if in compliance with internal temperature requirements and properly identified.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06D03a2</b>	Beef, pork, lamb, and equine carcasses and parts for boning are wholesome. Designated plant employee removes foreign material and defects prior to boning. Adequate help, facilities, and equipment is provided for reinspection.	<b>18.10 Manual Charts 18.1, 18.1-A</b>	<p>Randomly select one or more carcasses and/or parts after establishment trimming and prior to boning to determine if foreign material and/or other defects are removed. Evaluate available records.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06D Boning/Cutting/Breaking

<b>06D04a2</b>	Boneless meats free of defects, acceptably coded into lots. Competent plant employee is assigned to assist FSIS inspector during selection and inspection of samples. Rejected lots are identified, reconditioned, and presented for reinspection.	<b>18.10 Manual Charts 18.1, 18.1-A</b>	Randomly select one or more containers from identified lots. Select one or more 12-lb units from each container. Inspect each sample unit, applying criteria from Manual charts 18.1 or 18.1-A. Accept, reject, or draw additional sample units as necessary. Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.
<b>06D05a1</b>	Approved QC procedure for on-line/lot-based reinspection of boneless meat and poultry is implemented and monitored by the plant as approved, including corrective action where required.	<b>18.6 18.10 Manual Charts 18.1, 18.1-A Approved QC Procedure</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06D05a2</b>			Randomly select one or more 30-lb sample units (or any amount specified in an approved QC procedure) and perform boneless meat reinspection. Observe reinspection techniques and classification of defects by plant personnel to determine if acceptable. Observe plant's disposition of lots of product when a rejection limit is reached. Confirm that all product on hand is reworked and reinspected as identified in the approved QC procedure.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06D Boning/Cutting/Breaking

<b>06D06a1</b>	Approved QC program for mechanically separated (species) product (MSSP) is implemented and monitored by the plant as approved, including corrective action where needed.	<b>319.5(e)(2) Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06D06a2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Randomly select one or more containers from one or more lots and check product identification, condition, temperature, holding time/storage for compliance. Randomly select one or more lots of deboned product and check for temperature, holding time, and proper usage of product. Observe plant's sampling procedures to ensure program compliance. If results do not meet standards, determine if the plant initiated acceptable action as required by the QC program. If the plant has not taken corrective action, you will initiate appropriate action.</p>
<b>06D07a2</b>	Raw materials for mechanically deboned poultry in wholesome condition; deboned product cooled within 2 hours from time of exposure.	<b>18.37</b>	<p>Check deboned product exposure time (time product exposed to room temperature after deboning) prior to chilling. Check one or more containers from one or more lots in mechanical deboning area or storage area to determine compliance of raw materials with identification, condition, and temperature requirements.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06D Boning/Cutting/Breaking

<b>06D08a2</b>	Product sampled as required. Bone solids content does not exceed 1 % calculated on a weight basis.	<b>381.117(d)</b>	<p>Check one or more containers from one or more lots in mechanical deboning area or storage area to determine compliance of product with bone solids content requirement.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06D09a1</b>	Approved QC program for mechanically deboned poultry implemented and monitored by the plant as approved, including corrective action when required.	<b>Approved QC Program</b>	<p>Evaluate available records to determine if on file, timely, accurate, and complete.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06D09a2</b>			<p>Check room temperature to determine compliance. Observe plant's monitoring and sampling procedure to ensure program compliance.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06E Ground Meat/Poultry Processing

<b>06E01a1</b>	Formulation and ingredients properly identified; products are formulated according to posted formula. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.21</b> <b>318.6(a)</b> <b>319.15</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06E01a2</b>			Select at random one or more batches of product during formulation and check one or more ingredients for proper identification and accurate weights. If used, calculate for maximum amount of beef cheek meat to determine compliance with approved formula. Observe one or more in-process tests to determine total fat.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06E02a1</b>	QC programs for formulating CN-labeled ground meat and poultry product implemented and monitored by the plant as approved, including corrective action when needed.	<b>FSIS Dir.</b> <b>7239.4</b> <b>(Rev.1)</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06E02a2</b>			Observe plant's weighing, time/temperature requirements, use of limits, and corrective action of one or more batches/lots.  If results do not meet compliance standards, initiate appropriate action.  _____



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06F pH Requirements

<b>06F01a1</b>	Control the formulation of pickling solution according to the approved QC program.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06F01a2</b>			Verify the formulation of one or more batches of pickling solution.  If results do not meet compliance standards, initiate appropriate action.
<b>06F02a1</b>	Shelf-stable acidified products that are <i>not</i> heat-processed (e.g., "cold-packed"), must attain a pH of 4.6 or lower for each batch of product. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Agency Policy Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06F02a2</b>			Verify pH on one or more batches of pickling solution and/or product.  If results do not meet compliance standards, initiate appropriate action.
<b>06F03a1</b>	Control the formulation of meat product to be pickled according to the approved QC program.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06F03a2</b>			Verify the formulation of one or more batches of meat product to be pickled.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06G Moisture/Protein Ratio Requirements

<b>06G01a1</b>	Products formulated with properly identified and accurately weighed restricted and other ingredients as identified in approved formula and/or QC program.	<b>18.21</b> <b>318.6(a)</b> <b>318.7(c)(4)</b> <b>318.10</b> <b>319.106</b> <b>Approved</b> <b>QC Program</b> <b>Labeling</b> <b>Policy Book</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06G01a2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Select at random one or more batches of product during formulation and check one or more ingredients for proper identification and accurate weights. Calculate for maximum amount of one or more restricted ingredients used to determine compliance with approved formula.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06G02a1</b>	Moisture/protein ratio control is according to approved QC program and approved label (non-certified pork used).	<b>Approved</b> <b>QC Program</b>	<p>Evaluate available records to determine if on file, timely, accurate, and complete.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p>
<b>06G02a2</b>			<p>Verify that moisture/protein ratio is in accordance with approved QC program and approved label (noncertified pork used).</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# **INSPECTION SYSTEM GUIDE**

## **06 PRODUCT HANDLING AND PREPARATION**

### **06G Moisture/Protein Ratio Requirements**

**06G03a1**

Product heat-treated to reach required minimum internal temperature as well as meeting approved drying procedures (air/oven dried) during any stage of the process. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**06G03a2**

**18.32**  
**319.106**  
**(c)(5)(6)(7)**  
**Approved**  
**QC Program**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

Check minimum internal temperature of products required to be heat-treated. Check room temperature of one or more drying rooms. Check one or more lots of product scheduled for release to determine number of days product held in drying rooms and number of days product is held after curing materials are added.

If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06H Bacon Processing

<b>06H01a1</b>	Bacon, dry salt cured bellies/ jowls, meat, restricted ingredients and other nonmeat ingredients properly identified and accurately weighed as identified in approved procedure or QC program.	<b>18.32(c) 318.7 (b)(c)(1) Labeling Policy Book Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06H01a2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Select at random one or more lots of products during formulation and check one or more ingredients for proper identification and use of accurate weights. Calculate for correct amount of pre-weighed ingredients to assure compliance with approved procedure.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06H02a1</b>	Product properly identified. Percent of pumping meets approved procedure.	<b>18.32(c) 319.107 Approved Procedure</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06H02a2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Select at random one or more specified increments of product and weigh before and after pumping. Calculate percent of pumping to determine compliance with approved procedure. Observe tags or marks to assure product is properly identified.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06H Bacon Processing

<b>06H03a1</b>	Time, temperature (internal), and shrink meets approved smoke-house procedure.	<b>319.104 Approved Procedure FSIS Instructions</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06H03a2</b>			If results do not meet compliance standards, initiate appropriate action.
<b>06H03a2</b>			Select at random one or more specified increments of product and weigh pieces either in or out of smokehouse to determine percent of shrink and compliance with approved procedure. Determine internal temperature and time in smokehouse. Observe tags or marks to assure product is properly identified. Correlate calculations from in/out weighings done at separate times.
<b>06H04a1</b>	Time and shrink meets approved cooler procedure.	<b>Approved Procedure FSIS Instructions</b>	If results do not meet compliance standards, initiate appropriate action.
<b>06H04a2</b>			Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06H04a1</b>			If results do not meet compliance standards, initiate appropriate action.
<b>06H04a2</b>			Select at random one or more specified increments of product and weigh pieces either in or out of cooler to determine percent of shrink and compliance with approved procedure. Determine time in cooler. Observe tags or marks to assure product is properly identified. Correlate calculations from in/out weighings done at separate times.
<b>06H04a2</b>			If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06H Bacon Processing

**06H05a1**

Finished weight of dry salt cured bellies/jowls does not exceed 10% pickup.

**Labeling  
Policy Book  
Approved  
Procedure  
FSIS  
Instructions**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

**06H05a2**

Select at random one or more lots and verify finished weight pickup compliance by the following calculation:

$$\frac{\text{Finished Wt} - \text{Green Wt}}{\text{Green Wt}} \times 100$$

If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06I Dry/Semidry Fermented Sausage and Dry Cured Country Ham Processing

06I01a1	Formulation and ingredients properly identified; products formulated according to posted formula; and chopping, grinding, and stuffing meets requirements. If noncertified pork is used, product is treated to destroy trichinae according to Regulations. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	18.21 19.3(b) 318.6(a) 318.10 Labeling Policy Book Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.
06I01a2			If results do not meet compliance standards, initiate appropriate action.
06I02a1	Formulation and ingredient weight control for low sodium and/or sodium claim QC program implemented and monitored by the plant as approved, including corrective action when needed.	Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.
06I02a2			If results do not meet compliance standards, initiate appropriate action.
			Check the formulation of one or more lots and verify accuracy of sodium claim.
			If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06I Dry/Semidry Fermented Sausage and Dry Cured Country Ham Processing

<b>06I03a1</b>	Time/yield for curing and salt equalization meets procedure standard.	<b>319.106 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06I03a2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Select at random one or more lots of product released from curing and salt equalization process. Check for identification, yield, and total number of days product was held to determine compliance with approved procedures.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06I03b1</b>	Fermentation curing time, drying room temperature, and drying time to control moisture/protein ratio according to approved QC program and approved label (non-certified pork used).	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06I03b2</b>			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Check room temperature of one or more drying rooms. Check lot release schedules to determine number of days product is held in drying rooms and number of days product is held after curing for compliance with approved QC program.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# **INSPECTION SYSTEM GUIDE**

## **06 PRODUCT HANDLING AND PREPARATION**

### **06I Dry/Semidry Fermented Sausage and Dry Cured Country Ham Processing**

<b>06I04a2</b>	Minimum temperature in drying room (Method 1) does not exceed 45° F and approved procedure.	<b>318.10</b>	Check at random room temperature of one or more drying rooms.  If results do not meet compliance standards, initiate appropriate action.
<b>06I05a2</b>	Time product is held in drying room must be at least 20 days (Method 1). Product shall not be removed from drying room in less than 25 days from the time curing materials are added during formulation. Plant must notify FSIS when product is scheduled for release from drying room.	<b>318.10</b>	Check one or more lots scheduled for release; or evaluate from plant's records, time requirement of FSIS approved release during inspector's absence. Determine if scheduled release from drying room meets compliance standards.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06J Rendering

<b>06J01a2</b>	Raw materials are wholesome.	<b>18.19(b)(3)</b> <b>18.53</b> <b>(a)(b)(c)</b>	Randomly select one or more pounds of raw material from one or more lots/shipments and examine for wholesomeness. Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.
<b>06J02a2</b>	Different species of fat are handled separately, properly identified; pipe lines, tanks, etc., are properly identified. Plant provides separate equipment to assure product identity of rendered animal fats/animal fat by-products. (Also requires separation for vegetable oils.) Equipment used interchangeably is properly identified. Pipelines are above level of blending tank contents.	<b>18.52</b> <b>18.54</b> <b>317.8(b)</b> <b>(18)(19)(21)</b>	Verify that different species of fat are handled separately, properly identified; pipelines, tanks, etc., are properly identified; separate equipment is maintained to assure product identity of rendered animal fats/animal fat byproducts. (Also requires separation for vegetable oils.) Equipment used interchangeably is properly identified. Pipelines are above level of blending tank contents. Tour facility and observe all facilities/equipment specific to rendering. Check for compliance with separation/interchangeability requirement.  If results do not meet compliance standards, initiate appropriate action.
<b>06J03a2</b>	Product sampled hourly by designated plant employee where swept surface heat exchangers are used; filters saved for examination by FSIS personnel. Magnetic traps or filters used on heat exchangers are examined daily by designated employee. FSIS notified if foreign material is detected. Shaft, scrapers, and barrels of heat exchangers are examined by designated plant employee every six months for scoring, gouging, chipping, etc.	<b>18.54</b>	Perform filter examination on filters plant is required to save for observation. For plants using swept surface heat exchangers, examine shaft, scrapers, and barrel for scoring, gouging, chipping, etc., and for presence of contaminants (metal, plastic, etc.). Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06J Rendering

<b>06J04a2</b>	Raw materials for partially defatted (beef or pork) fatty tissue, PDBFT/ PDPFT, and partially defatted chopped beef (or pork), PDCB/ PDCP, is from recent production, stored in room with temperature less than 50° F. Kill floor fats may be moved within plant directly to rendering. Meat used for PDCB/ PDCP contains at least 12% lean naturally attached.	<b>18.55</b> <b>319.15(e)</b> <b>319.29(a)</b>	Randomly select one or more containers of raw material and check ID tag or use other means to determine if product is from recent production. Check storage room temperature. Observe plant sampling and/or knife cutting separation of lean meat. Compare plant's findings to visual observations. Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.
<b>06J05a2</b>	Low-temperature rendered product does not exceed 120° F; product has a pinkish color and a fresh odor and appearance.	<b>319.15(e)</b> <b>319.29(a)</b>	Observe plant's processing of one or more lots PDBFT/PDPFT— PDCB/PDCP and check a 1-lb sample or more for color, odor, and appearance. Check plant's conformance with low temperature rendering constraint of 120° F. Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.
<b>06J06a2</b>	Product leaves refrigeration cycle of process at 40° F or less, and is rapidly frozen to 30° F within a 6-hour period unless used in product immediately.	<b>18.55(3)(4)</b>	Observe plant's time/temperature compliance for one or more lots/ batches, etc., with requirements for chilling and freezing. Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06J Rendering

<b>06J07a2</b>	Beef greaves and pork crackling produced in accordance with provisions of approved labels.	<b>Labeling Policy Book Approved Label</b>	<p>Observe plant's compliance for one or more lots and/or one or more day's production of beef greaves or pork cracklings with approved label requirements. Evaluate available records.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06J08a2</b>	Pork skins for rendering are free from inverted hair follicles.	<b>18.53(d)(2)</b>	<p>Observe pork skin for rendering into lard for compliance with defects [18.53(d)(1)-(4)]. Evaluate available records.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06J09a2</b>	Oleomargarine contains at least 80% fat.	<b>317.2(f)(iii) 317.8(b) 319.700</b>	<p>Observe plant's compliance for one or more lots and/or one or more day's production of oleo with regulations. Observe plant's sampling procedure to determine compliance with target (% of lean meat) sample size, frequency, and testing method.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06J Rendering

<b>06J10a1</b>	Approved QC program for low-temperature rendering and export to Japan implemented and monitored by the plant as approved, including corrective action.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06J10a2</b>			Observe plant's processing of PDBT/PDFT and check one or more 1-lb sample for color, odor, and appearance for compliance. Check plant's conformance with low-temperature rendering constraint of 120° F. Observe plant's time/temperature for one or more lots/batches, etc., of product to determine chill and freezing compliance.  If results do not meet compliance standards, initiate appropriate action.
<b>06J11a2</b>	Pork skins for popping are in sound condition, properly identified, and meet product standards listed in Table 18.13 of the Manual.	<b>18.55(c) Labeling Policy Book Approved Label</b>	Randomly select one carton from each lot; or randomly select popped skins (prior to packaging) from the lot. Randomly select an overlay and inspect 10 sample units in each block to determine compliance with Table 18.13. Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06J Rendering

<b>06J12a1</b>	Approved QC program for pork skins for popping implemented and monitored by the plant as approved, including corrective actions.	<b>Manual Table 18.13 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06J12a2</b>			If results do not meet compliance standards, initiate appropriate action.  Randomly select one or more lots of pork skins during heat processing. Check product identification and frying procedures to determine compliance with approved procedures, Manual Table 18.13, or approved QC program.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06K Cooked Beef, Roast Beef, and Cooked Corned Beef Processing

<b>06K01a2</b>	Time and temperature for defrosting not to exceed those stated in approved procedure.	<b>318.17</b>	<p>Check temperature of one or more units or lbs for proper handling, time, and temperature.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06K02a1</b>	Product lotted, trimmed, sized or weighed, and identified as required. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>318.17 Approved QC Program</b>	<p>Evaluate available records to determine if on file, timely, accurate, and complete.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06K02a2</b>			<p>Check lotting, trimming, sizing or weight variations, and proper identification of lots.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06K03a1</b>	Solution for injection, massaging, or marination made according to QC program.	<b>Approved QC Program</b>	<p>Evaluate available records to determine if on file, timely, accurate, and complete.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>06K03a2</b>			<p>Observe formulation of one or more solutions to verify accuracy. Select one or more solutions to verify accuracy. Select one or more ingredients, weights and compare to formulation.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06K Cooked Beef, Roast Beef, and Cooked Corned Beef Processing

<b>06K04a1</b>	Solutions for injection, massaging, or marination is maintained at 50° F or less and is filtered each time it is recycled. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>318.17 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06K04a2</b>			Check temperature, filtering, and recirculation of one or more lots of one or more solutions.  If results do not meet compliance standards, initiate appropriate action.
<b>06K04b1</b>	Solution and/or rub is discarded at the end of the day's production unless it is in continuous contact with one batch of product. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>318.17 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06K04b2</b>			Check to see if solution and/or rub is discarded at the end of day's production unless it is in continuous contact with one batch of product.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06K Cooked Beef, Roast Beef, and Cooked Corned Beef Processing

**06K05a1**

Addition of solution to cooked corned beef complies with limit in approved procedure or addition of solution to roast beef and cooked beef complies with approved label application.

**Approved  
QC Program**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

**06K05a2**

Observe method of application. Select one or more batches or one or more lbs of product. Weigh before and after solution is applied. Calculate percent gain as follows:

$$\frac{\text{Pumped/Massaged Wt} - \text{Green Wt}}{\text{Green Wt}} \times 100$$

If results do not meet compliance standards, initiate appropriate action.

**06K06a1**

Product begins cooking cycle within 2 hours of completion of pre-cooking process or is put into a cooler maintained at 40° F or less. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**318.17  
Approved  
QC Program**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

**06K06a2**

Check one or more lots to determine that product is cooked within 2 hours or moved to a cooler maintained at 40° F or less.

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06K Cooked Beef, Roast Beef, and Cooked Corned Beef Processing

06K07a1	Time and temperature cooking requirements identified in approved procedures are met.	318.17 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
06K07a2			Observe time and temperature procedures used by the plant and compare to approved procedures.  If results do not meet compliance standards, initiate appropriate action.
06K08a1	Pieces of meat not to touch or overlap during immersion, cooking, and cooling other than incidental contact caused by water currents. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	318.17 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
06K08a2			Check product placement prior to the start or during the cooking cycle.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06K Cooked Beef, Roast Beef, and Cooked Corned Beef Processing

<b>06K09a1</b>	Time, temperature, and monitoring equipment are accurate: time within 1 minute, temperature within 1° F, humidity within 5%. Determine recording device accuracy by using 318.304-305 as a guideline. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>318.17</b> <b>318.304-305</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06K09a2</b>			Check and observe accuracy of clock, temperature recording devices, and humistat.  If results do not meet compliance standards, initiate appropriate action.
<b>06K10a1</b>	Cooking methods must comply with specifications identified in Section (b) or (c) of the regulation. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>318.17</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06K10a2</b>			Verify that cooking methods used by the establishment are in compliance with the standard.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06K Cooked Beef, Roast Beef, and Cooked Corned Beef Processing

<b>06K11a1</b>	Time/temperature requirements to be met before any product is removed from cooking. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>318.17 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06K11a2</b>			If results do not meet compliance standards, initiate appropriate action.  _____
			Observe recording charts for proper time/temperature requirements. Verify the internal temperatures.
			If results do not meet compliance standards, initiate appropriate action.
<b>06K12a1</b>	Plant must begin chill cycle within 90 minutes after cooking. Chill from 120° F to 55° F within 6 hours. Chill until product is 40° F. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>318.17 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06K12a2</b>			If results do not meet compliance standards, initiate appropriate action.  _____
			Check and observe chilling time/temperature of lots.
			If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06K Cooked Beef, Roast Beef, and Cooked Corned Beef Processing

<b>06K13a1</b>	Product handled to assure it is not recontaminated by direct or indirect contact with raw product. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>318.17 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06K13a2</b>			Observe product handling to assure no cross-contamination between raw and cooked product.  If results do not meet compliance standards, initiate appropriate action.
<b>06K14a1</b>	Product temperature is 40° F or less before packing. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>318.17 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06K14a2</b>			Check product temperature prior to packing.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06K Cooked Beef, Roast Beef, and Cooked Corned Beef Processing

<b>06K15a1</b>	If cooking process deviation occurs, reprocess the product, continue heating to 145° F, or contact Regional Director for approval of cooking process. If cooling process deviation occurs, contact Regional Director to determine disposition.	<b>318.17 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06K15a2</b>			If results do not meet compliance standards, initiate appropriate action.  _____
			Check for cooking or cooling process deviations.
			If results do not meet compliance standards, initiate appropriate action.
<b>06K16a2</b>	Weight of finished product shall not exceed the weight of the fresh uncured beef cut for cooked corned beef.	<b>319.101 319.102</b>	Verify that the finished product does not exceed the green weight on one lot of cooked corned beef using the calculation:
			$\frac{\text{Finished Wt} - \text{Green Wt}}{\text{Finished Wt}} \times 100$
			If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06K Cooked Beef, Roast Beef, and Cooked Corned Beef Processing

<b>06K17a1</b>	Cooked corned beef and X% added ingredients product complies with percentage declaration on approved label. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06K17a2</b>			Verify that the yield on one lot of product complies with the percent declaration on the approved label. Calculate % of yield using the formula:  $\frac{\text{Finished Wt} - \text{Green Wt}}{\text{Finished Wt}} \times 100$  If results do not meet compliance standards, initiate appropriate action.
<b>06K18a1</b>	Product complies with percentage label declaration of solution remaining after cook for roast beef or cooked beef (only if dual declaration on approved label). QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06K18a2</b>			Verify the yield on one or more lots of product. Calculate the percentage declaration of solution to assure label declaration is accurate using the following formula:  $\frac{\text{Finished Wt} - \text{Green Wt}}{\text{Finished Wt}} \times 100$  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06L Contaminated Product Reprocessing

06L01a1	Plant responsible for contacting FSIS prior to initiating procedure. Product segregated and identified. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	FSIS Dir. 7310.4 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06L01a2			Observe identification and control of retained products.  If results do not meet compliance standards, initiate appropriate action.
06L02a1	Equipment specifications and sensitivity meet requirements. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	FSIS Dir. 7310.4 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06L02a2			Observe test procedure/detection equipment with one or more seeded samples during re-examination of suspected product.  If results do not meet compliance standards, initiate appropriate action.
06L03a1	Plant management actions and disposition of contaminated product acceptable. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	FSIS Dir. 7310.4 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06L03a2			Observe denaturing and tanking of all unacceptable product.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06M Cured Beef Processing (Uncooked)

<b>06M01a1</b>	Product trimmed and/or formulated in compliance with FSIS-approved plant formulation. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06M01a2</b>			Observe the formulation of one batch of product to determine that QC program is being followed.  If results do not meet compliance standards, initiate appropriate action.
<b>06M02a1</b>	Pickle solution identified and formulated according to plant procedure. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.32 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06M02a2</b>			Select at random one or more batches of curing solution during formulation and check for proper identification. Check one or more pre-weighed ingredients (e.g., nitritie, ascorbate) for compliance with approved procedure.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06M Cured Beef Processing (Uncooked)

**06M03a1**

Finished product cannot contain more than:

- 10% A.S.—Corned Beef
- 20% A.S.—Corned Beef Brisket

**06M03a2**

QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**319.100**

**319.101**

**319.102**

**Approved  
QC Program**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

Select at random one type of product and weigh one or more pieces/pounds before and after pumping. Calculate to determine maximum percent of gain. Observe one or more product ID tags to determine proper identification.

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06N Miscellaneous Poultry Processing

06N01a1	Products formulated with accurately weighed poultry, nonmeat restricted, and nonmeat unrestricted ingredients. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	Part 18 381.147(d) Approved QC Program Approved Label	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06N01a2			Verify formulation of one or more products, checking ingredients for proper identification and accurate weights. Calculate restricted ingredient level to ensure maximum levels not exceeded.  If results do not meet compliance standards, initiate appropriate action.
06N02a1	Rework product incorporated into similar product. Approved QC program for rework control. Implemented and monitored by the plant as approved, including corrective action where required.	Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06N02a2			Select one or more lots/batches of product and verify the amount of rework added to like product is at the rate identified in the approved QC program.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06N Miscellaneous Poultry Processing

<b>06N03a1</b>	Solutions for basting, marination, or curing of poultry products formulated with accurately weighed or metered restricted and other ingredients identified in approved procedure and/or QC program.	<b>18.32 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06N03a2</b>			_____  Verify formulation of one solution, checking ingredient weights for accuracy and calculating restricted ingredient level to ensure maximum levels not exceeded.  If results do not meet compliance standards, initiate appropriate action.
<b>06N04a1</b>	The approved QC program for addition of solution (basting, marinating, pumping, or curing poultry products) is implemented and monitored by the plant as approved, including corrective action where required.	<b>18.32 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06N04a2</b>			_____  Observe application of solution and weighing of product to determine if the procedure is followed. Select one or more batches or pieces of product; weigh before and after solution is applied, and calculate percent gain as follows:  $\frac{\text{Pumped/Massaged Wt} - \text{Green Wt}}{\text{Green Wt}} \times 100$  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06N Miscellaneous Poultry Processing

06N05a1	Batter and breading shall not exceed 30% (up to 65% breading if labeled "fritters") of the finished weight of the product. Approved QC program (batter and breading poultry product) is implemented and monitored by the plant as approved, including corrective action where required.	381.166 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06N05a2			Perform batter and breading pickup test on one subgroup (QC) or batch of product. Calculate pickup as follows:  $\frac{\text{Breaded Wt} - \text{Green Wt}}{\text{Breaded Wt}} \times 100$  If results do not meet compliance standards, initiate appropriate action.
06N06a2	Thawing media do not exceed 70° F and product does not exceed 50° F during thawing process.	381.65	Perform temperature check on one or more units of product being thawed to determine media and product temperature.  If results do not meet compliance standards, initiate appropriate action.
06N07a1	Drain loss or stuffing loss meets standard. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06N07a2			Observe plant's verification of stuffing loss.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06N Miscellaneous Poultry Processing

<b>06N08a1</b>	Smokehouse or cooking vat controls (wet bulb/dry bulb) and recording devices are accurate. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06N08a2</b>			Observe calibration of wet/dry bulb thermometers and recording devices at smokehouse or cooking vats.  If results do not meet compliance standards, initiate appropriate action.
<b>06N09a2</b>	All product cooked to minimum internal temperature.	<b>381.150</b>	Check one or more units of product in smokehouse or cooking vats for internal temperature.  If results do not meet compliance standards, initiate appropriate action.
<b>06N10a1</b>	Cook shrink meets standard. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06N10a2</b>			Calculate cook shrink on one or more trees or one batch of product.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06N Miscellaneous Poultry Processing

<b>06N11a1</b>	Chill shrink meets standard. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06N11a2</b>			If results do not meet compliance standards, initiate appropriate action.
<b>06N12a2</b>	During rapid cooling of product, the internal temperature does not remain between 130° F and 80° F for more than 1½ hours, nor between 80° F and 40° F for more than 5 hours. Product consisting of intact muscle (e.g., turkey breast) may be cooled according to 318.17. Cold storage temperatures, intermediate holding temperatures, and hot holding temperatures are met per FSIS Directive 7110.3 or 318.17. Exposed cooked meat shall not be held in the same area with raw product.	<b>318.17 FSIS Dir. 7110.3</b>	Select at random and verify internal temperature, cold storage temperature, and hot holding temperature of one or more pieces/units of cooked product from one or more trees, racks, etc., for compliance. Check storage of exposed cooked product for compliance with product holding.
			If results do not meet compliance standards, initiate appropriate action.

# **INSPECTION SYSTEM GUIDE**

## **06 PRODUCT HANDLING AND PREPARATION**

### **06N Miscellaneous Poultry Processing**

**06N13a1**

Finished product does not weigh more than the original weight of the turkey thigh meat used prior to curing. Complies with regulation 381.171 or label declaration specifying the amount of additional substances. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**06N13a2**

**381.171  
Approved  
QC Program**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

Verify that the yield on one lot of product complies with either regulation 381.171 or percent additional substance according to label declaration.

If results do not meet compliance standards, initiate appropriate action.

# **INSPECTION SYSTEM GUIDE**

## **06 PRODUCT HANDLING AND PREPARATION**

**060 Reserved**

**June 7, 1988**

**6-50**



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06P Allied Slaughter Activities

<b>06P01a2</b>	All edible byproducts are prepared and reinspected in accordance with requirements. Unworked byproducts are not permitted to accumulate; are free of contamination or abnormalities; and are promptly chilled.	<b>10.3(s)</b> <b>11.11(a)-(s)</b> <b>Beef Tripe</b> <b>Guideline</b>	Select at random one or more pieces or lbs of product to determine if regulatory requirements are met. Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.
<b>06P02a2</b>	Products are identified by "species" and "name" and any special trimmings are in accordance with requirements (e.g., beef heart meat, cheek trimmings, tongue trimmings, etc.).	<b>17.13(h)</b>	Select one or more pieces or lbs of product to assure proper identification and proper trimming. Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.
<b>06P03a2</b>	Unflushed natural casings are thoroughly flushed with clean water immediately prior to use as a product container. All beef bungs, beef middles, hog bungs, etc., to be used for food containers are presented for inspection, turned with the fat surface exposed.	<b>18.24(a)(2)</b> <b>318.5(h)(i)</b> <b>318.6(b)</b> <b>(1)(2)(3)</b>	Verify that unflushed natural casings are thoroughly flushed with clean water immediately prior to use as a product container; all beef bungs, beef middles, hog bungs, etc., to be used for food containers are presented for inspection, turned with the fat surface exposed.  If results do not meet compliance standards, initiate appropriate action.
<b>06P04a2</b>	Calves for cold skinning are free of dirty skins, bruises, grubs, lice, or other abnormalities; handled in a sanitary manner; and skinned from an overhead rail.	<b>10.4(b)</b> <b>(1)(3)(4)</b>	Verify that calves for cold skinning are free of dirty skins, bruises, grubs, lice, or other abnormalities; handled in a sanitary manner; and skinned from an overhead rail.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06Q Miscellaneous Meat Processing

<b>06Q01a1</b>	Products formulated with accurately weighed meat, non-meat restricted, and nonmeat unrestricted ingredients. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Part 17, 18 318.6 318.7(c)(4) Approved QC Program Labeling Policy Book</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06Q01a2</b>			Verify formulation of one or more products, checking ingredients for proper identification and accurate weights. Calculate restricted ingredient level to ensure maximum levels are not exceeded.  If results do not meet compliance standards, initiate appropriate action.
<b>06Q02a1</b>	Rework product incorporated into similar product. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06Q02a2</b>			Select one or more lots/batches of product and verify the amount of rework added to like product is at the rate identified in the approved QC program.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06Q Miscellaneous Meat Processing

<b>06Q03a1</b>	Water-based solution for tenderization, marination, and addition to combination meats or uncured pork products formulated with accurately weighed or metered restricted and other ingredients identified in approved procedure and/or QC program.	<b>18.32 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06Q03a2</b>			Verify formulation of one or more solutions. Check ingredient weights and calculate restricted ingredient levels.  If results do not meet compliance standards, initiate appropriate action.
<b>06Q04a1</b>	The addition of solution meets the standards. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.16 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06Q04a2</b>			Observe application of solution and weighing of product to determine if the procedure is followed. Select one or more batches or one or more pieces of product; weigh before and after solution is applied, and calculate percent gain using the following formula:  $\frac{\text{Pumped/Massaged Wt} - \text{Green Wt}}{\text{Green Wt}} \times 100$  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06Q Miscellaneous Meat Processing

**06Q05a1**

Tenderization process provides adequate proteolysis test procedures to demonstrate the process complies with standards. Test equipment properly secured. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**06Q05a2**

#### 18.16 Approved QC Program Memo 66B

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

Monitor the plant's testing procedure for tenderization. Check:

- Sample source
- Sample size
- Water bath temperature
- Length of time sample is in bath water
- Extent of proteolysis
- Test security to determine compliance with plant's approved procedures

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06Q Miscellaneous Meat Processing

06Q06a1	Batter and breading shall not exceed 30% of the finished product weight. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	319.880 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06Q06a2			Perform batter and breading pickup test on one or more sub-groups (according to the QC program) or batch of the product.  $\frac{\text{Breaded Wt} - \text{Green Wt}}{\text{Breaded Wt}} \times 100$  If results do not meet compliance standards, initiate appropriate action.
06Q07a1	Smokehouse or cooking vat controls (wet bulb/dry bulb), cooking chambers, and recording devices are accurate. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06Q07a2			Observe calibrations of wet/dry bulb thermometers and recording devices for the smokehouse or cooking vats.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06Q Miscellaneous Meat Processing

<b>06Q08a1</b>	Product cooked to minimum internal temperature. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>318.10 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06Q08a2</b>			If results do not meet compliance standards, initiate appropriate action.  _____
			Check one or more units of product in smokehouse or cooking vats for internal temperature.
			If results do not meet compliance standards, initiate appropriate action.
<b>06Q09a1</b>	Barbequed meat is cooked by the direct action of dry heat. Product exhibits a crust formation from the rendering of surface fat and shrink a minimum of 30%. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>319.80 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>06Q09a2</b>			If results do not meet compliance standards, initiate appropriate action.  _____
			Select and weigh one or more pieces of product prior to cooking. Weigh one or more pieces after cooking. Calculate shrink percent. Check product appearance.
			If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06Q Miscellaneous Meat Processing

06Q10a1	During rapid cooling of product, the internal temperature does not remain between 130° F and 80° F for more than 1½ hours, nor between 80° F and 40° F for more than 5 hours. Product consisting of intact muscle (e.g., pork loin) may be cooled according to 318.17. Cold storage temperatures, intermediate holding temperatures, and hot holding temperatures are met per FSIS Directive 7110.3, approved QC program, or 318.17. Exposed cooked product shall not be held in the same area with raw product.	8.55(e) 318.17 FSIS Dir. 7110.3 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
06Q10a2			Select at random and verify internal temperature, storage temperature, intermediate holding temperature, and hot holding temperature of one or more pieces/units of cooked product from one or more trees, cages, racks, etc., for compliance. Check storage of exposed cooked product.  If results do not meet compliance standards, initiate appropriate action.
06Q11a1	Combination meat product complies with meat content as declared on FSIS-approved label. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	Approved QC Program Approved Label	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
06Q11a2			Verify the yield on one lot of product.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06Q Miscellaneous Meat Processing

**06Q12a1**

Uncured pork product complies with percentage label declaration of solution remaining after cooking (only if dual declaration on approved label).

#### Approved Label

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

**06Q12a2**

Verify the yield on one lot of product to determine if it complies with the percentage declaration of solution remaining after cooking according to approved label formulation.

$$\frac{\text{Finished Wt} - \text{Green Wt}}{\text{Finished Wt}} \times 100$$

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06R Custom/Retail Exempt Processing

<b>06R01a2</b>	Separate facilities or equipment and facilities cleaned and sanitized before they are used for preparing product for sale. Operation not a nuisance or cause unsanitary condition that affects area under inspection. Work schedule for retail operations on file and available to FSIS inspector.	<b>303.1</b>	Observe area where retail/custom activities are conducted to determine proper separation of facilities and products; hours worked agree with plant's identified schedule; special sanitation requirements are followed.  If results do not meet compliance standards, initiate appropriate action.
<b>06R02a1</b>	Records maintained on the amount and type of product prepared and the names and addresses of the owners of product.	<b>303.1</b>	Review plant records for accuracy (i.e., amount and type of product prepared, the names and addresses of owners of product.  If results do not meet compliance standards, initiate appropriate action.
<b>06R03a2</b>	Custom-exempt and retail-exempt product is properly identified and kept separated from inspected product.	<b>303.1(a)(2) (ii)(iii) 316.16 317.16</b>	Observe areas where custom products are stored and processed to determine separation and proper identification.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S01a1</b>	Establishment has process schedules/documents from a processing authority (PA) on file. Inspector is provided with a list of process schedules and any additional applicable information; if lists are not copies of PA documents, such lists are complete and accurate.	<b>318.302</b> <b>381.302</b>	Determine if establishment has process schedules/documents from a processing authority (PA) on file. Compare lists with PA documents as necessary.  If results do not meet compliance standards, initiate appropriate action.
<b>06S02a2</b>	Establishment will make no unauthorized changes to the original process schedules.	<b>318.302</b> <b>381.302</b>	Compare process schedules on file with those in use and determine if any unauthorized changes exist. Verify the check for one or more process schedules.  If results do not meet compliance standards, initiate appropriate action.
<b>06S03a2</b>	Products are prepared according to the formulation authorized in PA documents or by PA references to company documents (e.g., ingredient selection, amounts, specifications, sequence, method, equipment, and tests.)	<b>318.302</b> <b>318.303</b> <b>381.302</b> <b>381.303</b>	Check one or more formulations for one or more products and determine if the products are prepared according to the authorized formulation.  If results do not meet compliance standards, initiate appropriate action.
<b>06S04a2</b>	Incoming containers are evaluated and rejection actions taken if needed.	<b>318.301</b> <b>381.301</b>	Observe plant's evaluation procedures and review records, if kept.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S05a2</b>	Empty containers, roll stock for container forming, and lidding materials are acceptably clean and free from structural defects prior to filling.	<b>318.301</b> <b>381.301</b>	Check empty containers, roll stock for container forming, and lidding materials to determine cleanliness and freedom from structural defects.  If results do not meet compliance standards, initiate appropriate action.
<b>06S06a2</b>	Empty container handling practices (e.g., conveying, unscrambling, de-nesting, manual handling) are adequate to prevent soiling and damage.	<b>318.301</b> <b>381.301</b>	Check empty container handling practices to determine if adequate to prevent soiling and damage.  If results do not meet compliance standards, initiate appropriate action.
<b>06S07a2</b>	Containers are free of damage after filling. Product does not overlay seal area of unsealed containers after filling.	<b>318.301</b> <b>381.301</b>	Check five or more unsealed containers at one or more filling areas to detect damage and to determine if product overlays seal area.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

**06S08a1**

Critical factors specified in the process schedule are measured and recorded per written procedure filed with the inspector. If changes are desired, written procedures must be revised and submitted to FSIS before use.

**318.302-303**  
**381.302-303**

Evaluate written procedure for appropriateness.

If results do not meet compliance standards, initiate appropriate action.

**06S08a2**

Check one or more of the following critical factors as applicable to determine if measurement and recording are according to written procedure:

- Minimum headspace
- Maximum fill weight
- Maximum drained weight
- Maximum net weight
- Minimum ingredient (e.g., nitrite, salt, etc.)
- Percent solids
- Maximum pH
- Maximum water activity
- Sauce or packing media consistency
- Rotations per minute
- Filling sequence
- Filling method (e.g., hand fill, volume fill, tumble fill, etc.)
- Particle or slice size and weight
- Particle count
- Overpressure
- Residual gases
- Heating medium
- Others

If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S09a1</b>	Visual examinations of containers (all types) after closure are performed and results recorded at sufficient frequency to assure proper closure. Visual exams are also required at start-up and after jams or adjustment of the closing machine. Corrective action taken is recorded when necessary.	<b>318.301</b> <b>318.306-307</b> <b>381.301</b> <b>381.306-307</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06S09a2</b>	Determine if closing and machine discharge is causing container damage.		Observe plant's visual examinations of containers from one or more closing machines or perform visual examinations of containers from one or more closing machines.  If results do not meet compliance standards, initiate appropriate action.
<b>06S10a1</b>	Physical examinations of container seams or seals (destructive or nondestructive) are performed and results recorded at a frequency to assure proper closure. Specification guidelines on file and available to FSIS. Corrective action taken is recorded. Examine container manufacturer's end	<b>318.301</b> <b>318.306-307</b> <b>381.301</b> <b>381.306-307</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06S10a2</b>	seam or seal if applicable/required.		Observe plant's physical examinations or evidence of physical examinations.  If results do not meet compliance standards, initiate appropriate action.
<b>06S11a2</b>	The code mark on the container is permanent and legible and has required information.	<b>318.301</b> <b>381.301</b>	Check one or more finished product units to determine that container code is permanent and legible and has required information. If embossed, examine for code fractures.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S12a2</b>	Sealed containers are held no longer than two hours before retorting. (Shorter time specified or longer time permitted by the Administrator is met.)	<b>318.301</b> <b>381.301</b>	Check one or more assembled loading devices to determine that sealed containers are held no longer than the permitted time.  If results do not meet compliance standards, initiate appropriate action.
<b>06S13a2</b>	Crates or similar vehicles are loaded, handled, and unloaded without causing container damage. Some loading devices, designed to restrict container expansion during processing, are constructed and used in accordance with the process schedule.	<b>318.305</b> <b>381.305</b>	Check one or more crates to determine container damage and, if applicable, whether racking systems are assembled correctly.  If results do not meet compliance standards, initiate appropriate action.
<b>06S14a1</b>	Operating process schedules and thermal process system operating procedures posted or readily available to retort or process system operators.	<b>318.304</b> <b>381.304</b>	Check posted process schedules and thermal process system's operating procedures to determine if recommendations of processing authority are met.  If results do not meet compliance standards, initiate appropriate action.
<b>06S14a2</b>			Determine if process schedules and procedures are posted or readily available to thermal process system operators.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S15a2</b>	Container flow is designed and controlled to prevent mixups of processed and unprocessed containers. Batch systems require each crate or similar loading vehicle to be marked with a heat-sensitive indicator.	<b>318.304</b> <b>381.304</b>	Assess at random one or more areas of container flow to determine if mixup of processed and unprocessed containers is prevented. Check at random one or more loading vehicle to determine if heat-sensitive indicator is used following required procedures.  If results do not meet compliance standards, initiate appropriate action.
<b>06S16a2</b>	Written procedures for determining initial temperature are on file and adequate. Procedures for determining initial temperature are properly performed by plant personnel. For operations placing containers in holding tanks or using water in the retort, provisions are made to prevent water from lowering the initial temperature below the prescribed minimum.	<b>318.304</b> <b>381.304</b>	Assess written procedure. Check at random to determine adequate control of initial temperature requirements.  If results do not meet compliance standards, initiate appropriate action.
<b>06S17a1</b>	Proper devices used to time thermal process events are accurate. If a digital clock that does not show seconds is used, a one-minute safety factor is added to the vent time and also to the process time. Times on recording thermometer charts correspond within 15 minutes to times entered on written processing records.	<b>318.304</b> <b>381.304</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06S17a2</b>			Check thermal processing room operations at random to determine adequate control of clock devices and recording of time on charts.  If results do not meet compliance standards, initiate appropriate action.



# **INSPECTION SYSTEM GUIDE**

## **06 PRODUCT HANDLING AND PREPARATION**

### **06S Thermal Processing**

<b>06S18a2</b>	Each thermal process system is equipped with one properly installed accurate calibrated thermometer (mercury in glass or other device approved by the Administrator) that can be easily read.	<b>318.305</b> <b>381.305</b>	Check one or more retort temperature devices to determine acceptability and readability.  If results do not meet compliance standards, initiate appropriate action.
<b>06S19a2</b>	For each thermal process system, time/temperature devices are properly installed, accurate, and provide a permanent record of processing: chart-type devices with correct working scale, degrees per inch, and range of temperature. Exceptions granted by Administrator. Recorder never reads higher than indicating device (e.g., mercury in glass thermometer). Provisions to prevent unauthorized changes are in place. If applicable, air-operated temperature controllers have adequate air filter systems.	<b>318.305</b> <b>381.305</b>	Check plant's use of time/temperature recording devices to determine accuracy of recordings and permanent record.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S20a1</b>	Establishment applies thermal process schedule and operates retorts as recommended by the processing authority. Required record entries are made at time of occurrence. Operators are under required supervision.	<b>318.305-306</b> <b>318.310</b> <b>381.305-306</b> <b>381.310</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06S20a2</b>			Observe thermal process cycles at random to determine plant's control of at least the following: <ul style="list-style-type: none"> <li>● Time steam on</li> <li>● Time/temperature vent closed</li> <li>● Initial temperature</li> <li>● Time/temperature start</li> <li>● Recording MIG temperatures</li> <li>● Time end</li> <li>● Other applicable requirements per 318.306 and 381.306</li> </ul> If results do not meet compliance standards, initiate appropriate action.
<b>06S21a2</b>	Still steam retort installed, operated, and maintained as required: indicating thermometer and recording thermometer probes, steam inlet, crate supports, steam spreader, bleeders, condensate removal, stacking equipment, muffling devices, vents, manifolds and manifold headers, operating procedures (including venting procedure). Also, for batch and continuous agitating steam retorts, retort or rotational speed timing; for hydrostatic retorts, water leg temperature maintenance, conveyor timing; for steam/air retorts: steam/air mixture level, circulation of medium, overpressure.	<b>318.305</b> <b>381.305</b>	Check in one or more retort systems for one or more functional design requirements.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S22a2</b>	Batch still retort with water installed, operated, and maintained as required: pressure recording, heat distribution documentation, crate supports, stacking equipment, drain valve, water level, air supply and controls, water recirculation, cooling water entry, retort come-up procedures and operating procedures. Also, for batch agitating with water: retort or reel speed timing.	<b>318.305</b> <b>381.305</b>	Check in one or more retort systems for one or more functional retort design requirements.  If results do not meet compliance standards, initiate appropriate action.
<b>06S23a2</b>	Atmospheric cookers installed, operated, and maintained as required: time/temperature recording device, heat distribution documentation, water level.	<b>318.305</b> <b>381.305</b>	Check in one or more systems for one or more functional design requirements.  If results do not meet compliance standards, initiate appropriate action.
<b>06S24a2</b>	Other systems installed, operated, and maintained as approved by the Administrator.		Check in one or more systems for one or more functional design requirements.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S25a2</b>	FMC universal retort as approved by Administrator installed, operated, and maintained as required: mercury in glass, other approved time/temperature measuring devices, charts, steam inlet, water-fill plate, water level, drain ports, carts or tray system, heat distribution, steam injectors, pressure recorders, divider plates.	<b>318.305</b> <b>381.305</b>	Check the operation of FMC universal retorting system for one or more required functional design components and operation requirements.  If results do not meet compliance standards, initiate appropriate action.
<b>06S26a2</b>	Post-processing cooling is accomplished with potable water or in an approved reuse or recycling system. System is cleaned, sanitized, and maintained as per filed information.	<b>318.305</b> <b>381.305</b>	Check one or more cooling cycles to determine adequate water usage or water reuse and sanitizer residual. System is cleaned, sanitized, and maintained per filed information.  If results do not meet compliance standards, initiate appropriate action.
<b>06S27a2</b>	Post-processing container handling equipment and procedures are adequate to prevent damage to seams/seals and minimize other damage. Equipment is maintained and acceptably clean.	<b>318.305</b> <b>381.305</b>	Randomly examine containers for damage. Evaluate equipment and procedures to determine if adequate for proper handling of containers. Determine if equipment is adequately maintained and acceptably clean.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

**06S28a1**

Establishment maintains all written records required by the Regulations or automatic monitoring is approved by the Administrator.

**318.306**  
**381.306**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

**06S28a2**

Check one or more of the plant's written records for one or more complete thermal process cycles for the following applicable items:

- Product name and style
- Initial temperature
- Code
- Actual process time
- Production date
- Retort number
- Indicating device reading
- Recording device reading
- Container size
- Operator's identity
- Number of containers
- Process schedule
- Time steam on
- Venting time/temperature
- Time process temperature reached
- Time in/out
- Time steam off
- Water level
- Overriding pressure
- Condensate bleeder
- Reel or conveyor speed
- Other records per 318.306 and 381.306

to determine conformance with Regulations.

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S29a2</b>	All records, including container evaluation records, are reviewed within one working day after processing.	<b>318.307</b> <b>381.307</b>	Check one or more day's recordings to determine if plant reviews records within one working day after processing.  If results do not meet compliance standards, initiate appropriate action.
<b>06S30a1</b>	Computer management record systems are maintained as approved by the Administrator.	<b>318.307</b> <b>381.307</b> <b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06S30a2</b>			Review and audit one or more computer-generated retort records to determine compliance with all applicable requirements.  If results do not meet compliance standards, initiate appropriate action.
<b>06S31a2</b>	Product distribution records are maintained as required by Regulations. Records are controlled by the establishment for 3 years.	<b>318.307</b> <b>381.307</b>	Observe distribution of one or more lots to determine if establishment identifies and records initial distribution of finished product.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

06S32a1	Process deviations are handled with FSIS, or by an approved QC program. File of process deviations is kept.	318.308 381.308 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06S32a2			Check plant's handling of process deviations or evidence of handling to determine isolation and control of retention, corrective action, documentation, and reporting requirements.  If results do not meet compliance standards, initiate appropriate action.
06S33a1	Plant reprocesses or repacks only with a process schedule authorized by the processing authority or by an approved QC program.	318.308 381.308 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
06S33a2			Check plant's reprocessing, or repacking and reprocessing, or evidence to determine that the process schedule is authorized, full documentation of production records is kept, and product is disposed of adequately.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S34a1</b>	Containers removed from jams of continuous rotary retorts, or other applicable equipment, receive proper processing deviation handling. When necessary, product in intake valves or transfer valves between cooker shells is destroyed. In lieu of above, approved QC program is followed.	<b>318.308</b> <b>381.308</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06S34a2</b>			Check plant's handling of jams or evidence of handling of jams to determine if affected containers are handled properly or destroyed.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06S35a1</b>	Establishment has an incubator with: <ul style="list-style-type: none"> <li>● Accurate recorder</li> <li>● Accurate thermometer</li> <li>● Means for circulation</li> <li>● Authorized entry</li> </ul>	<b>318.309</b> <b>381.309</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>06S35a2</b>	QC program is implemented and monitored by the plant as approved, including corrective action when necessary.		Check plant's container incubator to determine adequate: <ul style="list-style-type: none"> <li>● Recorder</li> <li>● Thermometer</li> <li>● Circulation</li> <li>● Security</li> </ul> Also, as applicable, check that establishment is following its approved QC program.  If results do not meet compliance standards, initiate appropriate action.  _____

# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S36a1</b>	Establishment's container incubation program complies with required time, temperature, range, sampling program, identification of product requiring incubation, checks, and records.	<b>318.309</b> <b>381.309</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06S36a2</b>			Check plant's incubation system or evidence of incubation to determine that all requirements of the applicable regulations or QC program are followed.  If results do not meet compliance standards, initiate appropriate action.
<b>06S37a1</b>	Abnormal containers are handled according to regulations or by an approved QC program. Notify Regional Director of abnormal container findings.	<b>318.309</b> <b>381.309</b> <b>FSIS Dir.</b> <b>7520.2</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06S37a2</b>			Check plant's handling of abnormal containers or evidence of handling of abnormal containers to determine that all requirements of the applicable regulations are followed.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 06 PRODUCT HANDLING AND PREPARATION

### 06S Thermal Processing

<b>06S38a1</b>	Condemned finished product is disposed of properly on site or destroyed off premises as required. If product is to be destroyed off premises, notify the Regional Director.	<b>318.308-309</b> <b>381.308-309</b> <b>FSIS Dir.</b> <b>7520.2</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06S38a2</b>			Check plant's handling of on-site destruction of condemned product or evidence of destruction of condemned product and/or documentation of destruction off premises to determine decharacterization and/or denaturation and documentation.  If results do not meet compliance standards, initiate appropriate action.
<b>06S39a1</b>	Condition of container examinations are adequate or establishment has approved QC program.	<b>318.308-309</b> <b>381.308-309</b> <b>FSIS Dir.</b> <b>7520.2</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>06S39a2</b>			Check plant's warehousing practices or evidence of practices to detect container abuse or wet or stained cases and to assess container examination procedures and protection from recontamination.  If results do not meet compliance standards, initiate appropriate action.
<b>06S40a2</b>	Establishment meets all applicable thermal processing equipment requirements, including ongoing maintenance and annual audit.	<b>318.305</b> <b>381.305</b>	Perform all or part of the canned food retort audit system as directed by FSIS.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 07 MARKING, BRANDING, LABELING, AND PACKAGING

### 07A Marking and Branding

<b>07A01a2</b>	The proper and legible marks of inspection are applied to all applicable products.	<b>Part 16</b> <b>312.2</b> <b>Part 316</b> <b>381.137</b> <b>381.138(a)</b> <b>FSIS Dir.</b> <b>6810.2</b>	Review brand imprints to determine if they are duplicated as prescribed.
	Brands are approved and used for intended purpose. Acceptable facilities are provided for storage and security of brands and other marking devices.	<b>316.2</b> <b>316.3</b> <b>317.3</b>	Check to determine that an accurate inventory of security items is maintained. Check brand boxes to assure adequate security.  If results do not meet compliance standards, initiate appropriate action.
<b>07A02a2</b>	Approved branding ink.	<b>16.11(d)</b> <b>316.5</b> <b>317.3</b> <b>List of</b> <b>Proprietary</b> <b>Substances</b> <b>and Nonfood</b> <b>Compounds</b>	Check to see if approved branding ink is used.  If results do not meet compliance standards, initiate appropriate action.
<b>07A03a2</b>	Custom-exempt product marked "Not For Sale."	<b>316.16</b>	Check if custom-exempt product is marked "Not For Sale."  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 07 MARKING, BRANDING, LABELING, AND PACKAGING

### 07B Labeling

<b>07B01a2</b>	Labels are approved by USDA and used as approved.	<b>317.2</b> <b>317.6</b> <b>381.115</b> <b>381.144</b> <b>FSIS Dir.</b> <b>7220.1</b> <b>7231.3</b>	<p>Check a sample of different labels to determine if labels are approved, correct, and used as intended.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>07B02a1</b>	Approved QC program for grade labeling implemented and monitored by the plant as approved, including corrective action where appropriate.	<b>FSIS Dir.</b> <b>6810.1</b> <b>(Rev. 1)</b> <b>Approved</b> <b>QC Program</b>	<p>Evaluate available QC records to determine if required records are on file, complete, and accurate.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>07B02a2</b>			<p>Check a sample of production to assure conformance with approved QC program.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>07B03a1</b>	Approved QC program for CN-labeled processes implemented and monitored by the plant as approved, including corrective action where appropriate..	<b>FSIS Dir.</b> <b>7239.4</b> <b>(Rev. 1)</b> <b>Approved</b> <b>QC Program</b>	<p>Evaluate available QC records to determine if required records are on file, complete, and accurate.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>07B03a2</b>			<p>Check a sample of production to assure conformance with approved QC program.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 07 MARKING, BRANDING, LABELING, AND PACKAGING

### 07B Labeling

**07B04a1**

Nonmeat CN-labeled products show production date and code on each case and are stamped "Officially Sampled." QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

#### Approved QC Program

Evaluate available QC records to determine if required records are on file, complete, and accurate.

If results do not meet compliance standards, initiate appropriate action.

**07B04a2**

Observe random cases for production date, case code, and USDA stamp (legibility and imprint).

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 07 MARKING, BRANDING, LABELING, AND PACKAGING

### 07C Net Content

<b>07C01a2</b>	Net weight calculations and statement are accurate.	<b>18.61</b> <b>317.2(h)</b> <b>381.121</b>	<p>Perform net weight inspection using the following lot inspection procedure:</p> <p>Randomly select 10 units from an assembled lot. Determine compliance according to Manual Table 18.18. When necessary, randomly select 30 additional units from same lot to make final decision for that lot of product.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>07C02a1</b>	Scales calibrated and tare weight established. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>18.61</b> <b>Approved</b> <b>QC Program</b>	<p>Evaluate available QC records to determine if required records are on file, complete, and accurate.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>07C02a2</b>			<p>Check one or more scales to determine accuracy. Randomly select the specified number of empty containers, weigh, and calculate the average weight.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>



# INSPECTION SYSTEM GUIDE

## 07 MARKING, BRANDING, LABELING, AND PACKAGING

### 07C Net Content

07C03a1	Approved QC program for net weight and drained weight control implemented and monitored by the plant as approved, including corrective action when required.	18.61(b) Approved QC Program	Evaluate available plant records to determine if required records are on file, complete, and accurate.
07C03a2			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>Weigh one or more subgroups. Calculate the average, range, run criteria, and individual limits. Compare your test results to compliance standards and initiate appropriate action as necessary.</p>
07C04a1	Declared count and/or vignette on label is accurate. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	18.63 18.64 317.8(a) 381 Approved QC Program	Evaluate available plant records to determine if required records are on file, complete, and accurate.
07C04a2			<p>If results do not meet compliance standards, initiate appropriate action.</p> <p>_____</p> <p>For declared count, select samples of one product according to the criteria in Table 18.20 of the Manual; or, for vignette sample, one or more lots. Select five units from the sampled lot. Inspect product, by halving or slicing, to determine if product is comparable in appearance and composition to that depicted in the vignette.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# **INSPECTION SYSTEM GUIDE**

## **07 MARKING, BRANDING, LABELING, AND PACKAGING**

### **07C Net Content**

**07C05a1**

Approved QC program for control of declared count or vignette labeling implemented and monitored by the plant as approved, including corrective action as required.

#### **Approved QC Program**

Evaluate available plant records to determine if required records are on file, complete, and accurate.

If results do not meet compliance standards, initiate appropriate action.

**07C05a2**

Perform declared count test according to the test procedure in the approved QC program on one sample of product. Compare your test results to plant's records and compliance standards. If results do not meet standards, initiate appropriate action.

# **INSPECTION SYSTEM GUIDE**

## **07 MARKING, BRANDING, LABELING, AND PACKAGING**

### **07D Packaging**

**07D01a1**

Packaging materials are USDA-accepted and properly used. Letters of guaranty are on file certifying that packaging material that contacts product meets all requirements. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**07D01a2**

**17.16**  
**(a)(b)(c)(d)**  
**317.20**  
**320.1(b)(5)**  
**381.144**  
**381.175(b)(2)**  
**FSIS Dir.**  
**7410.1**  
**Approved**  
**QC Program**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

Check random boxes of packaging material to determine if acceptable, properly used, and covered by letter.

If results do not meet compliance standards, initiate appropriate action.





# **INSPECTION SYSTEM GUIDE**

## **08 RETAINED, RETURNED, RESTRICTED PRODUCT**

### **08A Retained Product**

**08A01a2**

Properly identified facilities for retained product of size commensurate with need are provided to maintain security of retained product pending disposition. Such facilities provide appropriate refrigeration for the retained product if required.

**307.2(h)**  
**381.47(c)**  
**381.99**  
**Handbook**  
**570**

Verify that properly identified facilities for retained product of a size commensurate with need are provided to maintain security of the retained product pending disposition and that appropriate refrigeration for the retained product is provided if required.

If results do not meet compliance standards, initiate appropriate action.

# **INSPECTION SYSTEM GUIDE**

## **08 RETAINED, RETURNED, RESTRICTED PRODUCT**

### **08B Returned Product**

**08B01a1**

Returned goods are received into the designated area and not diverted to other areas until they are released by the proper authority. Proper disposition of returned goods is made. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**08B01a2**

**18.86(a)(b)**  
**25.6**  
**Approved**  
**QC Program**

Evaluate available plant records to determine if required records are on file, complete, and accurate.

If results do not meet compliance standards, initiate appropriate action.

Ensure that returned products are placed in designated area. Reinspect at random to determine if product separated by plant employees is acceptable. Observe plant condemning unmarked or unwholesome product.

If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 08 RETAINED, RETURNED, RESTRICTED PRODUCT

### 08C Restricted Product

<b>08C01a2</b>	<p>“Passed for Cooking” product is under the direct control of FSIS until the applicable treatment is accomplished. “Passed for Refrigeration” or “Passed for Heating” product is under direct control of FSIS until the applicable treatment is accomplished. Plant is responsible for contacting FSIS prior to initiating applicable treatment.</p>	<p><b>11.5(h)</b>  <b>310.6</b>  <b>311.23(2)</b>  <b>311.25(a)(b)</b>  <b>315.1</b>  <b>315.2</b>  <b>315.3</b>  <b>FSIS Dir.</b>  <b>6810.2A</b></p>	<p>Verify that product “Passed for Cooking” is under the direct control of FSIS until the applicable treatment is accomplished; that product “Passed for Refrigeration” or “Passed for Heating” is under the direct control of FSIS until the applicable treatment is accomplished; and that the plant contacts FSIS prior to initiating the applicable treatment.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>08C02a2</b>	<p>Only unaffected portions of carcasses of swine with tuberculosis but “Passed for Cooking” are used.</p>	<p><b>311.2</b>  <b>315</b></p>	<p>Verify that only unaffected portions of carcasses of swine with tuberculosis but “Passed for Cooking” are used.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 08 RETAINED, RETURNED, RESTRICTED PRODUCT

### 08D Trichinae Treatment

**08D01a2**

All applicable products are treated to destroy trichinae by refrigeration as required and have approved documented controls in place to certify treatment (inventory, security, recording devices, records, hi-lo thermometers, etc.)

**18.29**  
**318.10**

Evaluate procedure (time/temp) records. Observe total amount of pork (bags, boxes, etc.) and its placement in cage. Calculate to verify lot size. Check thickness (inches) of product to determine compliance with approved trichinae treatment method. Verify instrument accuracy with over/under thermometer; temperature of product; and plant security of product.

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 09 FINISHED PRODUCT STORAGE AND SHIPPING

### 09A Storage

<b>09A01a1</b>	Good warehousing is practiced to prevent damage to or contamination of containers. Hanging carcasses are prevented from contact with fixed objects or containers. Exposed product not stored beneath carcasses in coolers or holding areas. Recommended cooler temperature 40° F or less; for poultry products, 36° F or less. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>308.3(f)</b> <b>308.9</b> <b>381.66(b)</b> <b>Sanitation</b> <b>Handbook</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>09A01a2</b>			Check temperature in storage room; check condition of one or more boxes from skids, pallets, etc., to determine whether properly handled, properly closed.  If results do not meet compliance standards, initiate appropriate action.
<b>09A02a1</b>	Custom-exempt, retail-exempt, and/or State-inspected product, if any, is properly identified and kept separate from inspected product. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>303.</b> <b>1(a)(2)(ii)</b> <b>318.1</b> <b>(h)(1)(2)</b> <b>FSIS Dir.</b> <b>7310.4</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>09A02a2</b>			Verify that custom-exempt, retail-exempt, and/or State-inspected product, if any, is properly identified and kept separate from inspected product.  If results do not meet compliance standards, initiate appropriate action.



# **INSPECTION SYSTEM GUIDE**

## **09 FINISHED PRODUCT STORAGE AND SHIPPING**

### **09A Storage**

**09A03a1**

Exposed heat-processed product not stored in the same area with raw product or, if stored in the same area, the procedure is approved by the FSIS circuit supervisor. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**09A03a2**

**318.17  
FSIS Dir.  
11,000.2  
Approved  
QC Program**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

Check that exposed heat-processed product is not stored in the same area with raw product or is stored according to approved procedure.

If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 09 FINISHED PRODUCT STORAGE AND SHIPPING

### 09B Shipping

<b>09B01a1</b>	Vehicles are in good repair to protect the type of product to be transferred. Vehicles are clean and free of objectionable odors and foreign materials. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>308.9</b> <b>308.10(b)(c)</b> <b>FSIS Dir.</b> <b>11,000.2(XD)</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>09B01a2</b>			Check one or more vehicles to determine if clean and properly equipped.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>09B02a1</b>	Records fully and correctly disclose all transactions subject to the Meat and Poultry Inspection Acts. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>320.1</b> <b>320.3</b> <b>320.4</b> <b>320.6</b> <b>381.175-</b> <b>381.178</b> <b>Approved</b> <b>QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.  _____
<b>09B02a2</b>			Check one or more records to determine if all transactions are fully and correctly disclosed under the Meat and Poultry Inspection Acts.  If results do not meet compliance standards, initiate appropriate action.  _____





# INSPECTION SYSTEM GUIDE

## 10 CONTROL OF INEDIBLE AND CONDEMNED MATERIAL

### 10A Condemned and Inedible Facilities

<b>10A01a1</b>	Facilities are adequate, separate from facilities handling edible products. Meet FSIS guidelines and plant's sanitary practices. Preclude cross-contamination from inedible departments to edible departments. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	14.3 14.8 14.22 307.2(i) 308.5 314.2 <b>Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>10A01a2</b>			If results do not meet compliance standards, initiate appropriate action.  Observe facilities and plant's practices for handling condemned and inedible products to assure elimination of cross-contamination. Require condemned products to be held under acceptable security until appropriate disposition.  If results do not meet compliance standards, initiate appropriate action.
<b>10A02a1</b>	Equipment and containers are clean and in good repair; containers are properly identified and secured. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	14.18 308.5 <b>FSIS Dir. 11,220.1 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>10A02a2</b>			If results do not meet compliance standards, initiate appropriate action.  Randomly select one or more containers and determine that uniform, distinct markings are applied. Check the selected containers for rust, corrosion, and cleanliness. Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.

# INSPECTION SYSTEM GUIDE

## 10 CONTROL OF INEDIBLE AND CONDEMNED MATERIAL

### 10B Product Control

<b>10B01a1</b>	All condemned products are placed in watertight containers labeled "U.S. Condemned"; all containers for inedible products are conspicuously identified "Inedible." QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>307.2(e) Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>10B01a2</b>			If results do not meet compliance standards, initiate appropriate action.
<b>10B02a1</b>	All salvage of condemned and/or inedible products for animal food is conducted in accordance with applicable established rules. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>14.18 14.20 14.21 14.22 314.10(b) 314.11 Approved QC Program</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
<b>10B02a2</b>			If results do not meet compliance standards, initiate appropriate action.
			Check that all salvage of condemned and/or inedible products for animal food is conducted in accordance with applicable established rules.
			If results do not meet compliance standards, initiate appropriate action.

# **INSPECTION SYSTEM GUIDE**

## **10 CONTROL OF INEDIBLE AND CONDEMNED MATERIAL**

### **10B Product Control**

**10B03a1**

Where required, letters are on file from State officials approving removal of inedible and condemned material. QC program is implemented and monitored by the plant as approved, including corrective action when necessary.

**10B03a2**

#### **14.12 Approved QC Program**

Evaluate available records to determine if on file, timely, accurate, and complete.

If results do not meet compliance standards, initiate appropriate action.

Check to determine if proper letter/permit is on file and is of current date and that the provisions of the letter/permit are being followed. Evaluate available records.

If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 10 CONTROL OF INEDIBLE AND CONDEMNED MATERIAL

### 10C Denaturants

<b>10C01a1</b>	All condemned products are maintained under control until properly destroyed for human food purposes.	<b>14.4</b> <b>314.3(a)</b> <b>381.95</b>	Evaluate available records to determine if on file, timely, accurate, and complete.
	All condemned and inedible products are effectively treated (using approved methods) to preclude their diversion to human food use.	<b>14.15</b> <b>314.3(a)</b> <b>325.13</b>	If results do not meet compliance standards, initiate appropriate action.
<b>10C01a2</b>	Undenatured inedible and condemned materials intended for animal food are handled in accordance with established guidelines.		Observe condemned inedible product storage and handling to assure approved methods, no cross-contamination, and proper storage.
	QC program is implemented and monitored by the plant as approved, including corrective action when necessary.	<b>Approved</b> <b>QC System</b>	If results do not meet compliance standards, initiate appropriate action.

# **INSPECTION SYSTEM GUIDE**

## **11 RESIDUES, SAMPLING, AND PRODUCT ANALYSIS**

**11A Residue**

**Reserved**

# **INSPECTION SYSTEM GUIDE**

## **11 RESIDUES, SAMPLING, AND PRODUCT ANALYSIS**

### **11B Diagnostic Sampling and In-Plant Residue Monitoring**

**Reserved**



# INSPECTION SYSTEM GUIDE

## 11 RESIDUES, SAMPLING, AND PRODUCT ANALYSIS

### 11C-11U Processed Products Monitor Sampling

<b>11C01a2</b>	Cooked Sausage 10% added H <sub>2</sub> O 30% fat	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.
<b>11D01a2</b>	Cooked sausage 10% added H <sub>2</sub> O	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.
<b>11E01a2</b>	Italian sausage	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.
<b>11F01a2</b>	Fresh pork sausage	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.
<b>11G01a2</b>	Fresh beef sausage	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.
<b>11H01a2</b>	Breakfast sausage	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.
<b>11I01a2</b>	Smoked pork sausage	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.
<b>11J01a2</b>	Ground Beef/Hamburger Ground Pork	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.
<b>11K01a2</b>	Moisture-protein ratio controlled product	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.
<b>11L01a2</b>	Dry cured product	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.
<b>11M01a2</b>	pH controlled product	<b>23.2</b>	Randomly select sample. Process sample and mail to designated laboratory.

# INSPECTION SYSTEM GUIDE

## 11 RESIDUES, SAMPLING, AND PRODUCT ANALYSIS

### 11C-11U Processed Products Monitor Sampling

<b>11N01a2</b>	Corned beef hash	23.2	Randomly select sample. Process sample and mail to designated laboratory.
<b>11O01a2</b>	Reserved		
<b>11P01a2</b>	Mechanically deboned poultry	23.2	Randomly select sample. Process sample and mail to designated laboratory.
<b>11Q01a2</b>	PFF controlled product (QC verification only)	23.2	Randomly select sample. Process sample and mail to designated laboratory.
<b>11R01a2</b>	Fat percentage label claim product (QC verification only)	23.2	Randomly select sample. Process sample and mail to designated laboratory.
<b>11S01a2</b>	Sodium percentage label claim product (QC verification only)	23.2	Randomly select sample. Process sample and mail to designated laboratory.
<b>11T01a2</b>	Directed sampling	23.2 FSIS Dir. 10,520.1	Collect, process, and mail samples upon request from computer-generated instructions (PFF, bacon, species, etc.) or upon instructions from circuit supervisor, area office, regional office, or Washington headquarters.
<b>11U01a1</b>	Process/product sampled by establishment in accordance with provisions of the approved QC program. Corrective action initiated on noncompliant product in accordance with approved QC program.	318.4 381.145 Approved QC Program	Evaluate available records to determine if on file, timely, accurate, and complete.  If results do not meet compliance standards, initiate appropriate action.
<b>11U01a2</b>			Evaluate establishment QC laboratory results. Compare results to standards and review corrective action taken on noncompliant product. Initiate appropriate action when establishment fails to react to noncompliant results.

# INSPECTION SYSTEM GUIDE

## 12 EXPORT

### 12A Application for Export

**12A01a2**

A completed application or other request will be furnished to the inspection point with all pertinent information as follows:

1. Exporter's name and address.
2. Consignee's name and address.
3. Establishment number.
4. Country code.
5. Region code.
6. Date.
7. Shipping marks.
8. Pounds and type of product.
9. Number of certificates.
10. Certificates and type of request.
11. Signature or name of person making the request.
12. Person's title and name of company.
13. Date of request.

**FSIS Dir.  
9020.1  
9080.1**

Review the application or other requests to check that all pertinent information is included.

If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 12 EXPORT

### 12B Product Inspection

<b>12B01a2</b>	Meets all foreign country product specification requirements.	<b>FSIS Dir. 9000 Series</b>	<p>Check paperwork, certification, marking, and product to assure that foreign country product specifications are met.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>12B02a2</b>	Product must be of current production.	<b>FSIS Dir. 9000 Series</b>	<p>Check paperwork, certification, marking, and product to assure that product is within allowable production dates.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>12B03a2</b>	Export facilities must be acceptable for type of product to be exported.	<b>FSIS Dir. 9000 Series</b>	<p>Check export facilities to determine if acceptable for type of product exported.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>12B04a2</b>	Plant personnel are adequately trained to assist in export inspection.	<b>FSIS Dir. 9000 Series</b>	<p>Observe plant personnel assigned to assist in export inspection to determine if adequately trained.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>12B05a2</b>	Plant presents product to allow proper sampling.	<b>FSIS Dir. 9000 Series</b>	<p>Check lot to determine if product is accessible for random selection. Select containers for inspection, adequate marking, and labeling.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 12 EXPORT

### 12B Product Inspection

<b>12B06a2</b>	Containers must be in acceptable condition.	<b>FSIS Dir. 9000 Series</b>	<p>Perform condition of container examination if required. Check acceptability of lot and evaluate records.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>12B07a2</b>	Frozen samples must be in an acceptable state for inspection.	<b>FSIS Dir. 9000 Series</b>	<p>Determine if frozen samples are in acceptable condition for inspection.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>12B08a1</b>	Only product in good condition may be exported.	<b>FSIS Dir. 9000 Series</b>	<p>Evaluate available records.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>12B08a2</b>			<p>Observe product samples and overall lot to determine product condition.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>12B09a2</b>	Slaughter dates are provided on request.	<b>FSIS Dir. 9000 Series</b>	<p>Review foreign countries' requirements for slaughter dates; if required, observe slaughter dates and certification furnished by the applicant.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>

# INSPECTION SYSTEM GUIDE

## 12 EXPORT

### 12B Product Inspection

12B10a1	Export stamps.	FSIS Dir. 9000 Series	Evaluate available records.  If results do not meet compliance standards, initiate appropriate action.  _____
12B10a2			Observe the application of export stamp to the product.  If results do not meet compliance standards, initiate appropriate action.



# INSPECTION SYSTEM GUIDE

## 12 EXPORT

### 12C Certificate Completion/Issuance

<b>12C01a2</b>	Certificates are completed under FSIS security.	<b>FSIS Dir. 9060.1</b>	<p>Proofread all documents. Initial minor alterations. Void unusable certificates. Cancel unused space. Sign original and supplemental certificates.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>
<b>12C02a2</b>	Exporter distributes appropriate copies of certificates.	<b>FSIS Dir. 9020.1</b>	<p>Check if application original is sent to Data Center and duplicate is on file. Check if FSIS Form 9060.5 original is on file and all copies have been sent to exporter. Check if Others/Special are handled as indicated on form.</p> <p>If results do not meet compliance standards, initiate appropriate action.</p>



# **INSPECTION SYSTEM GUIDE**

## **13 IMPORTS**

**Reserved**

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